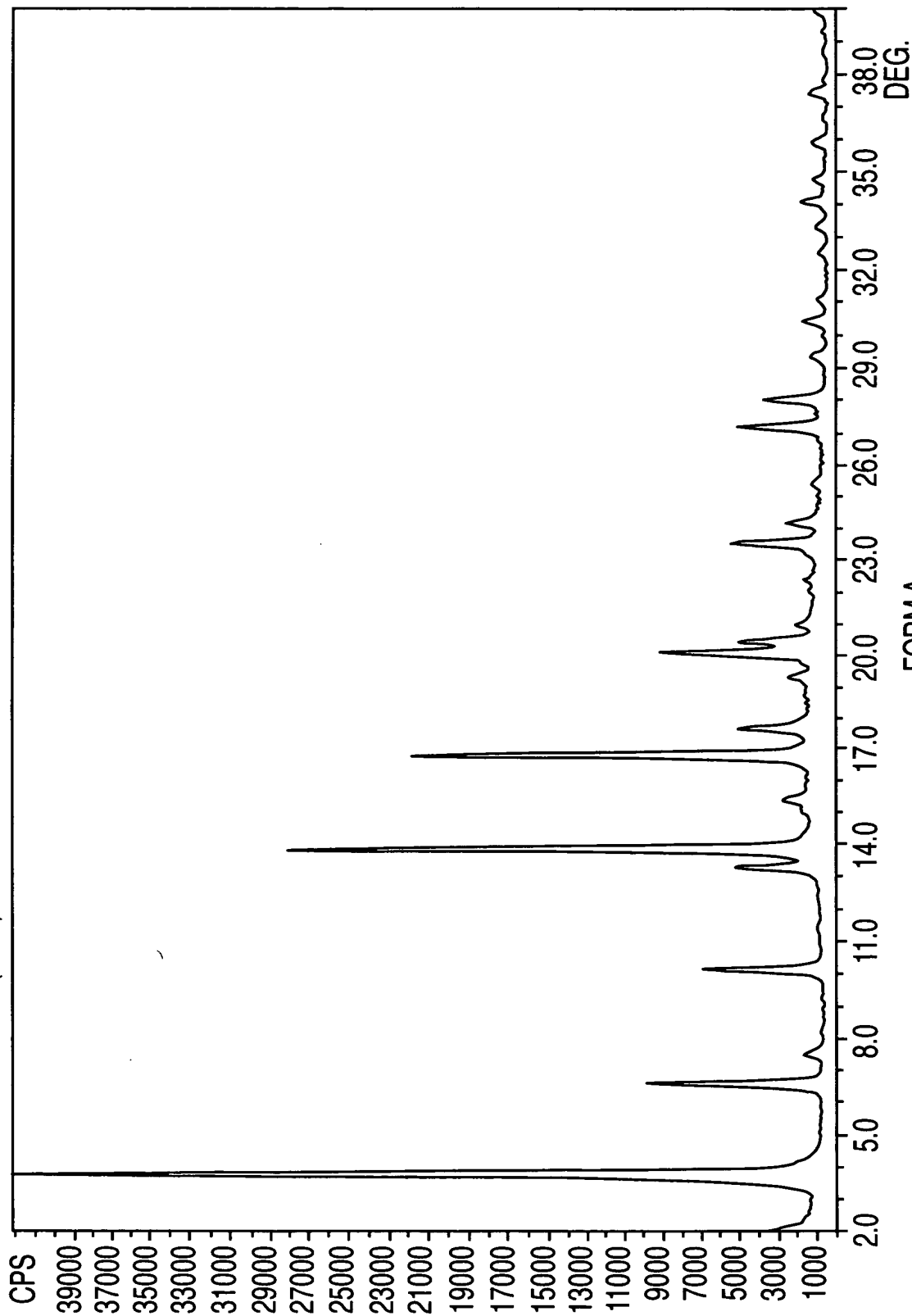




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STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORMA

FIG. 1

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.

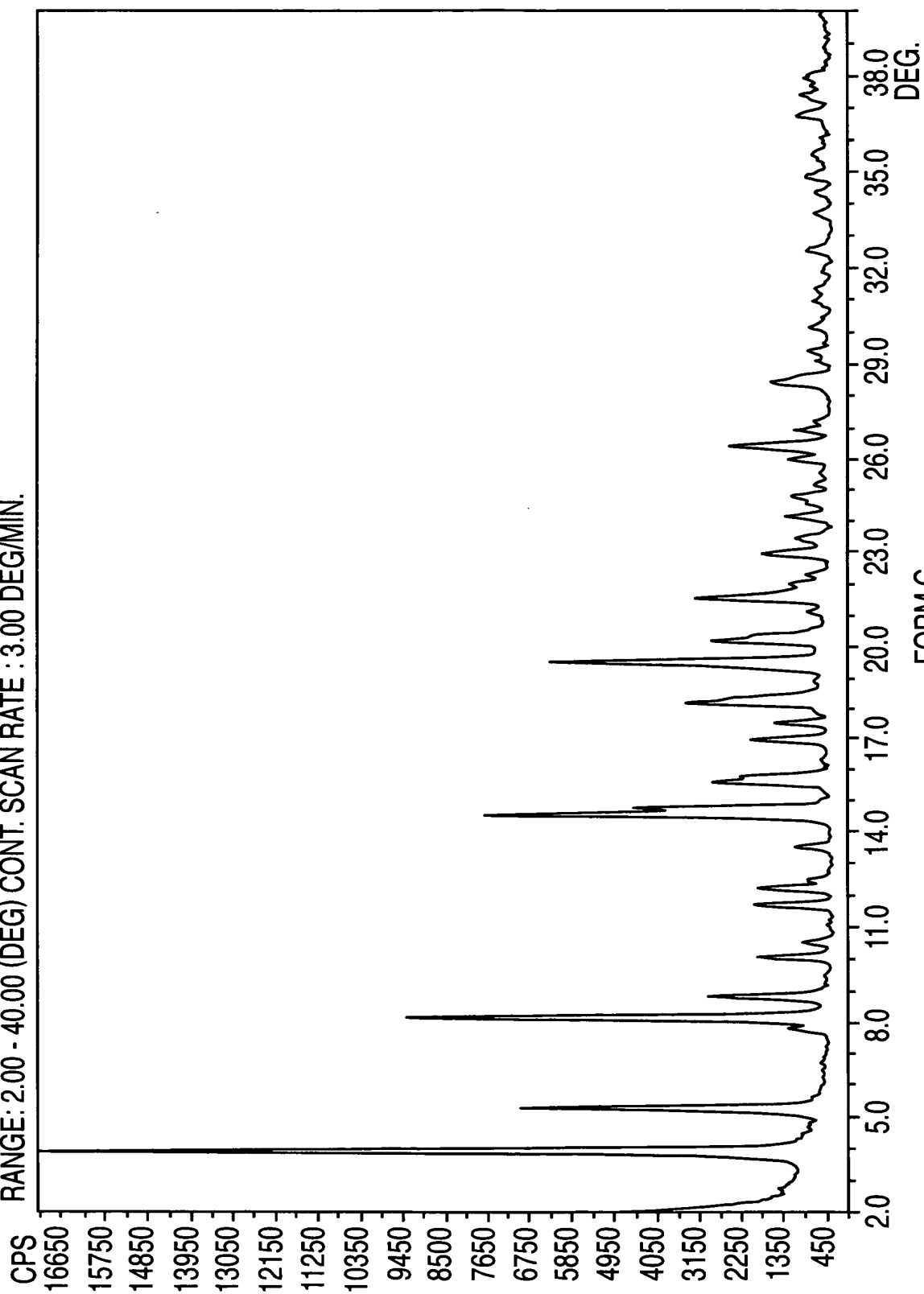


FIG. 2

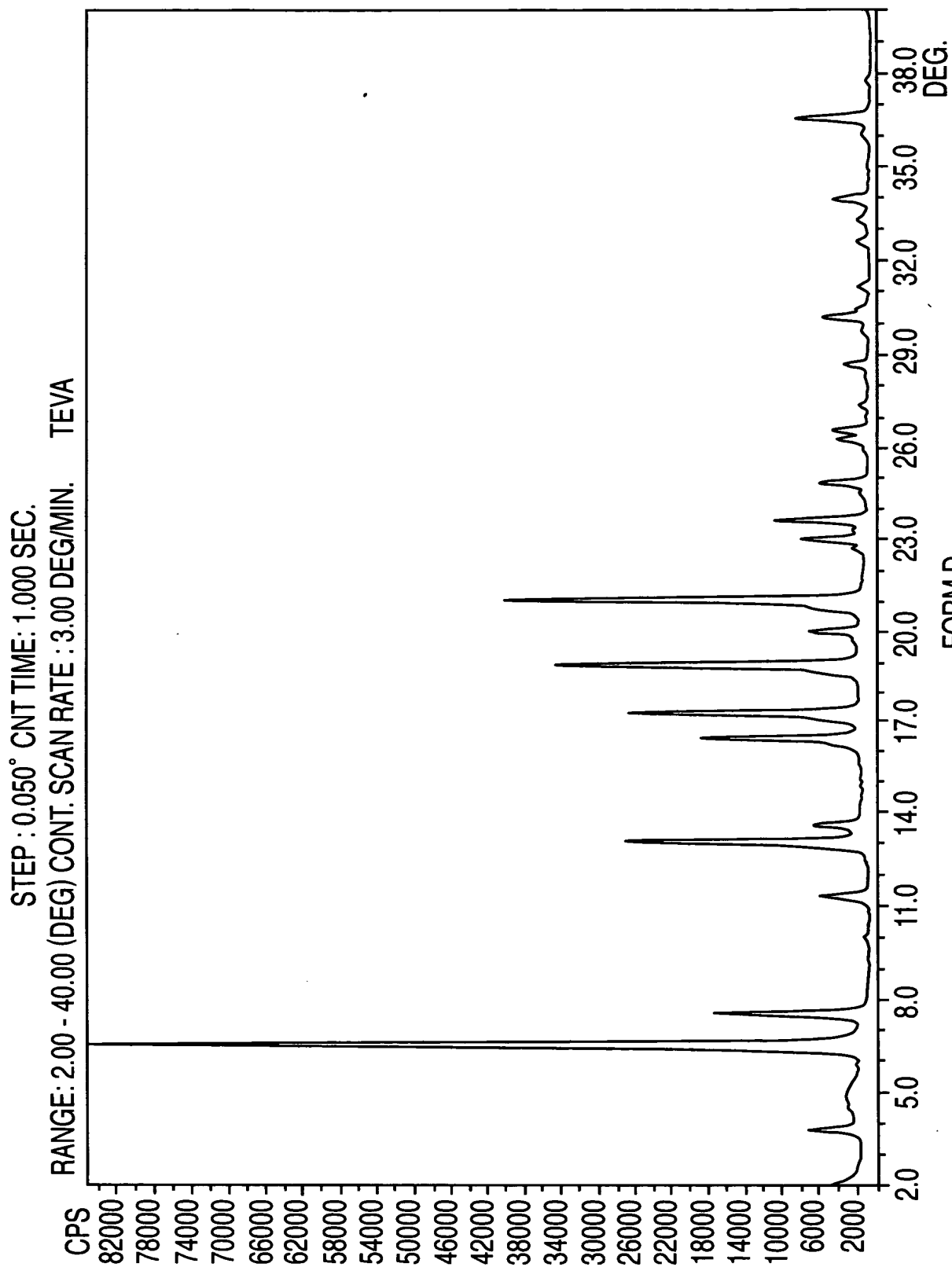
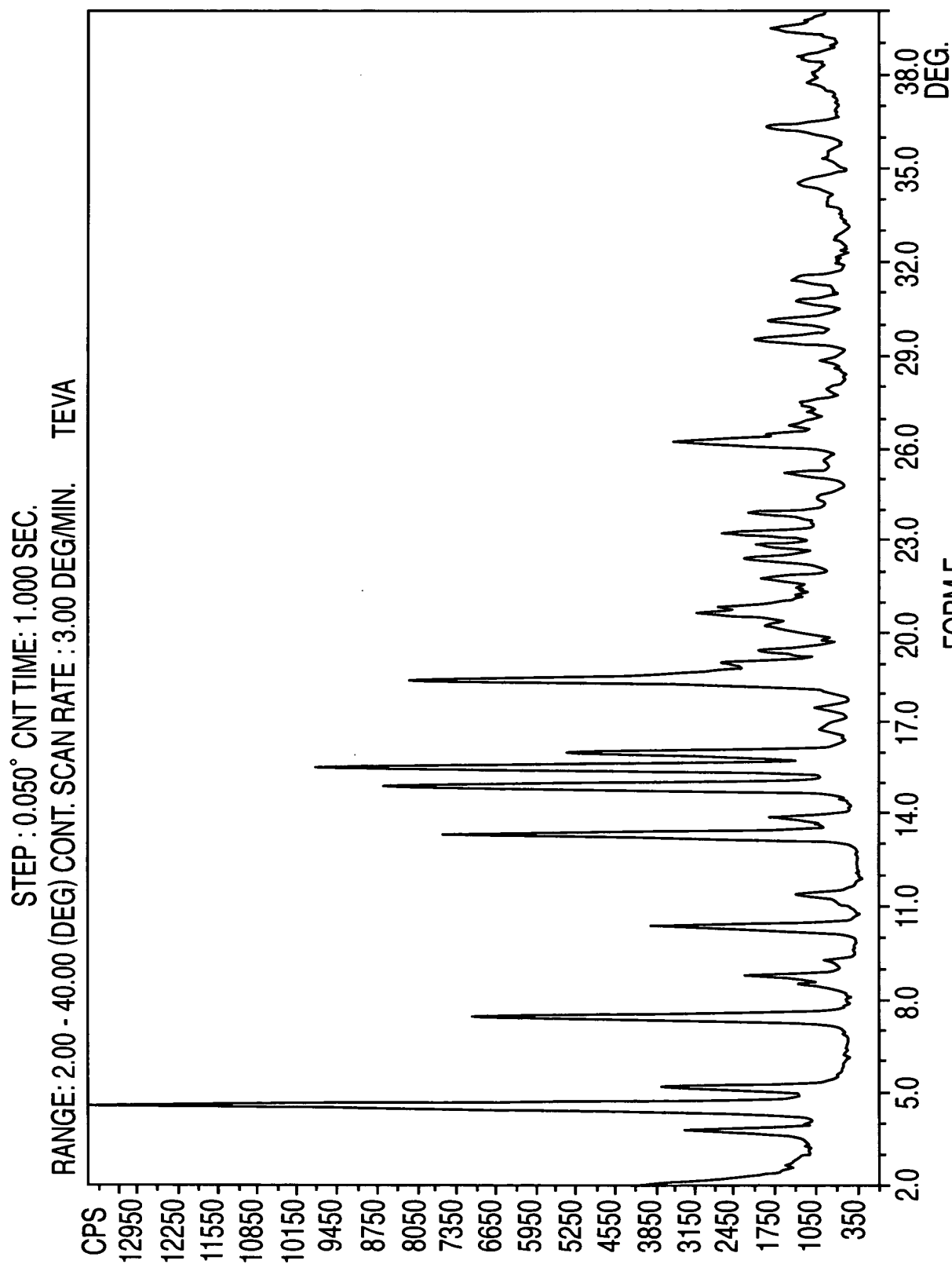
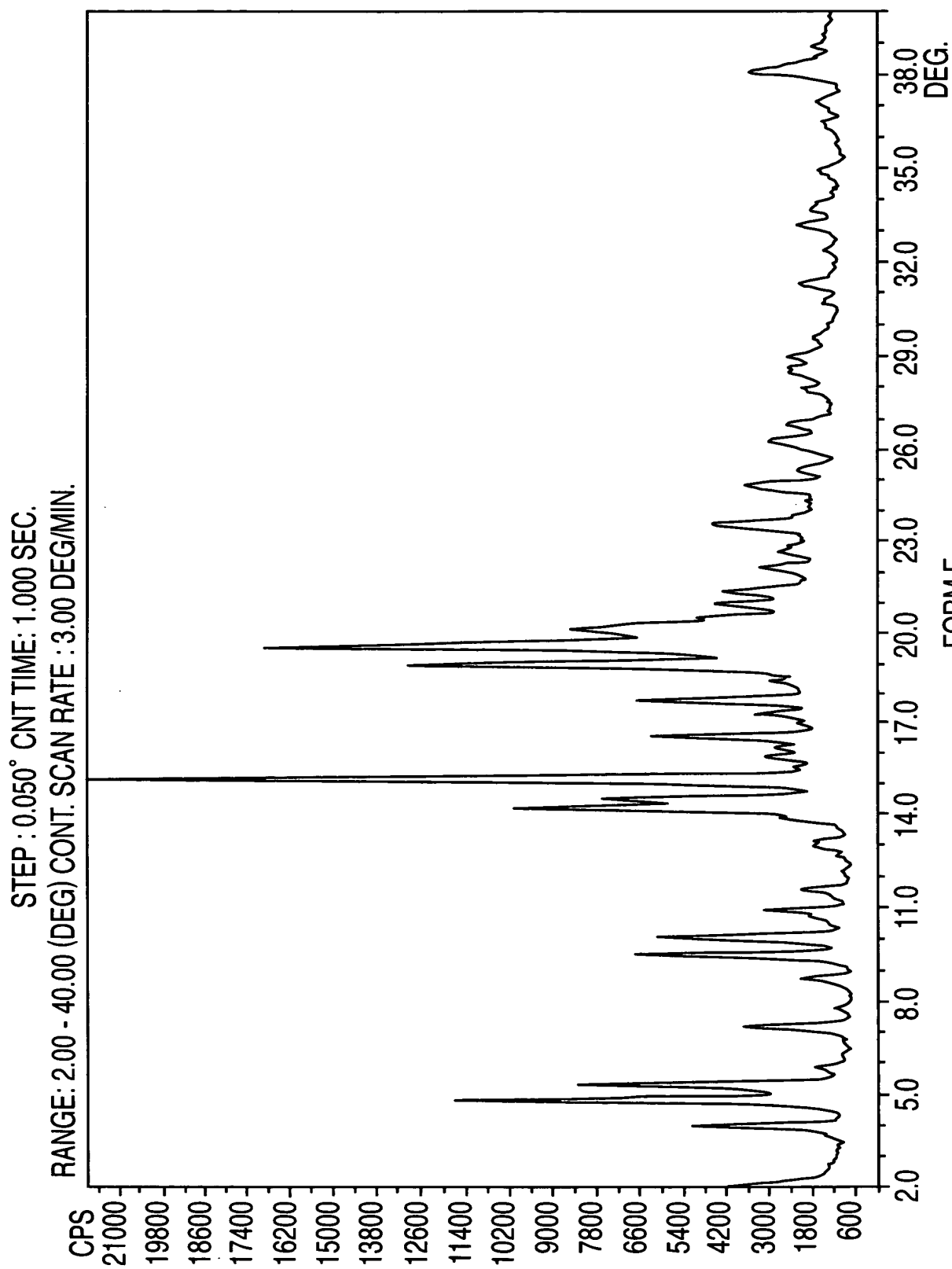


FIG. 3



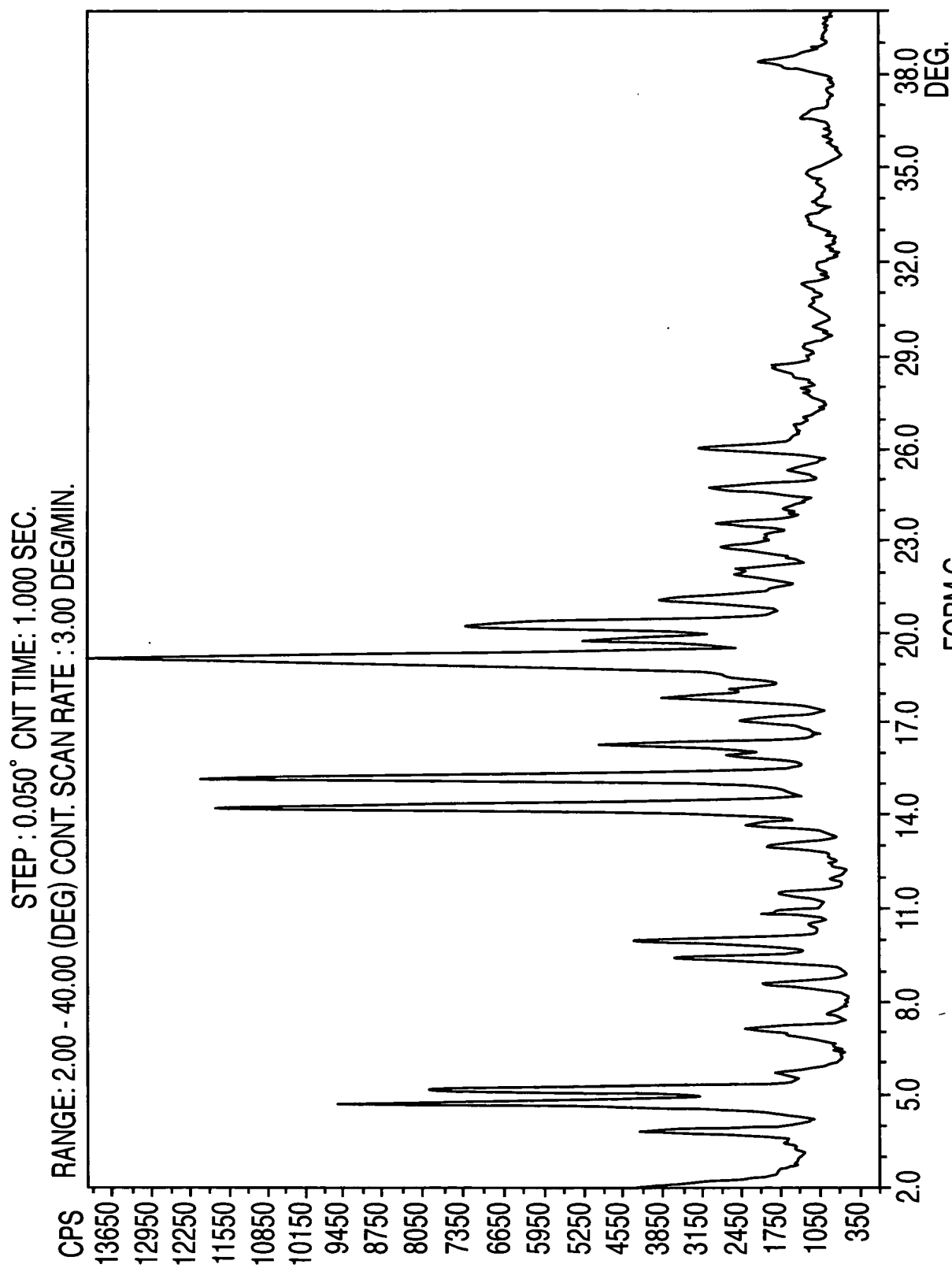
FORM E

FIG. 4



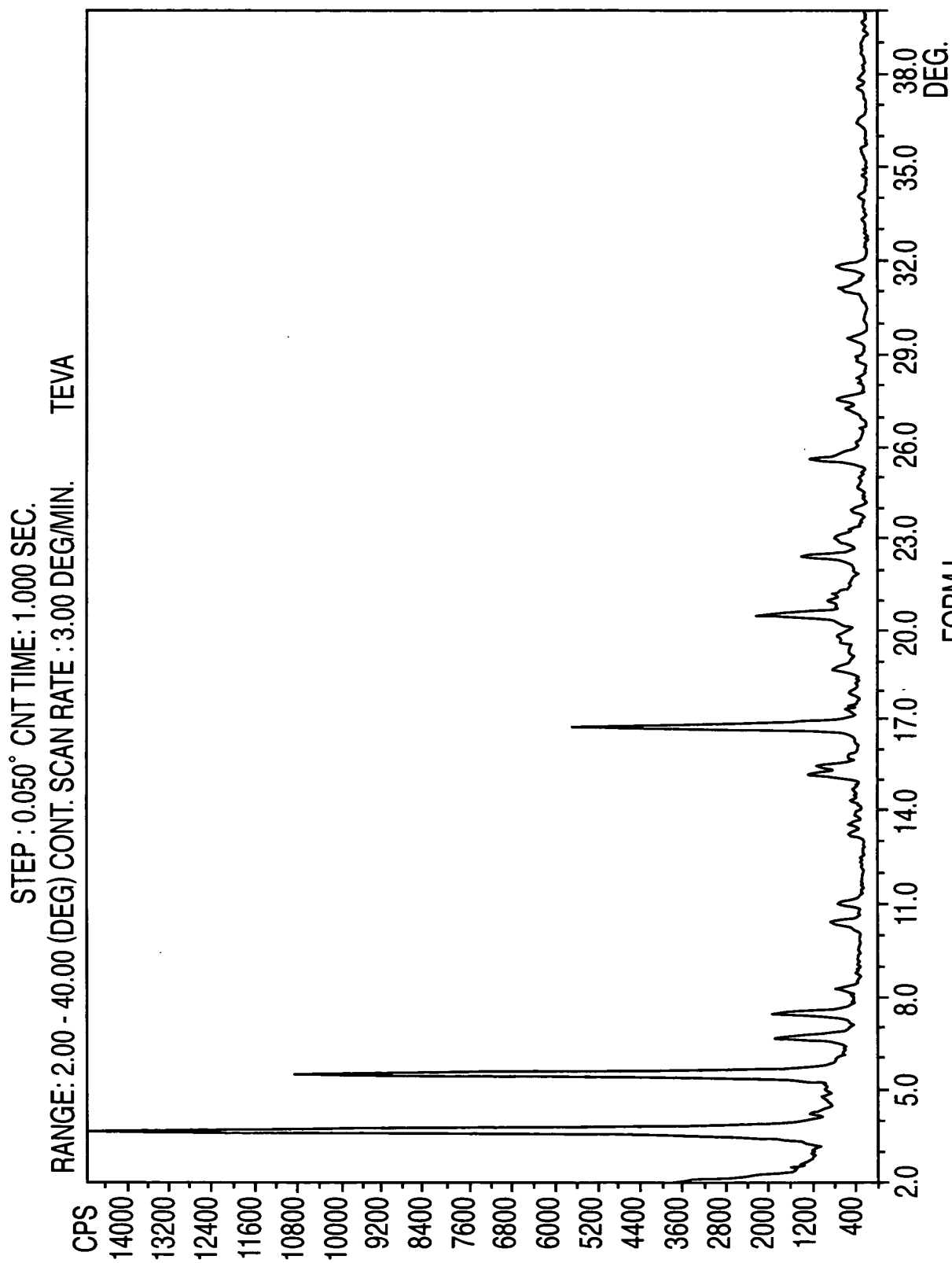
FORM F

FIG. 5



FORM G

FIG. 6



FORM I

FIG. 7

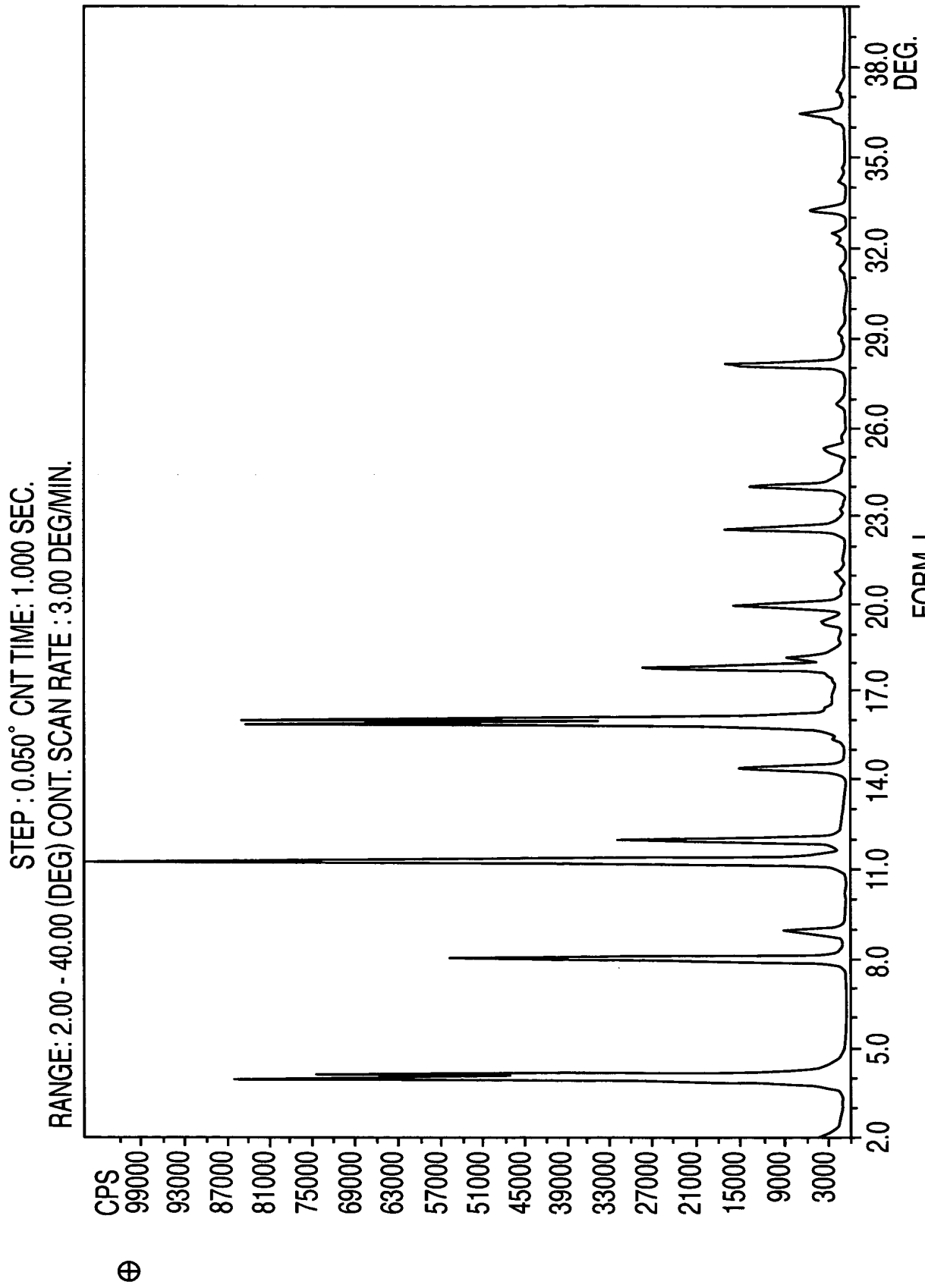
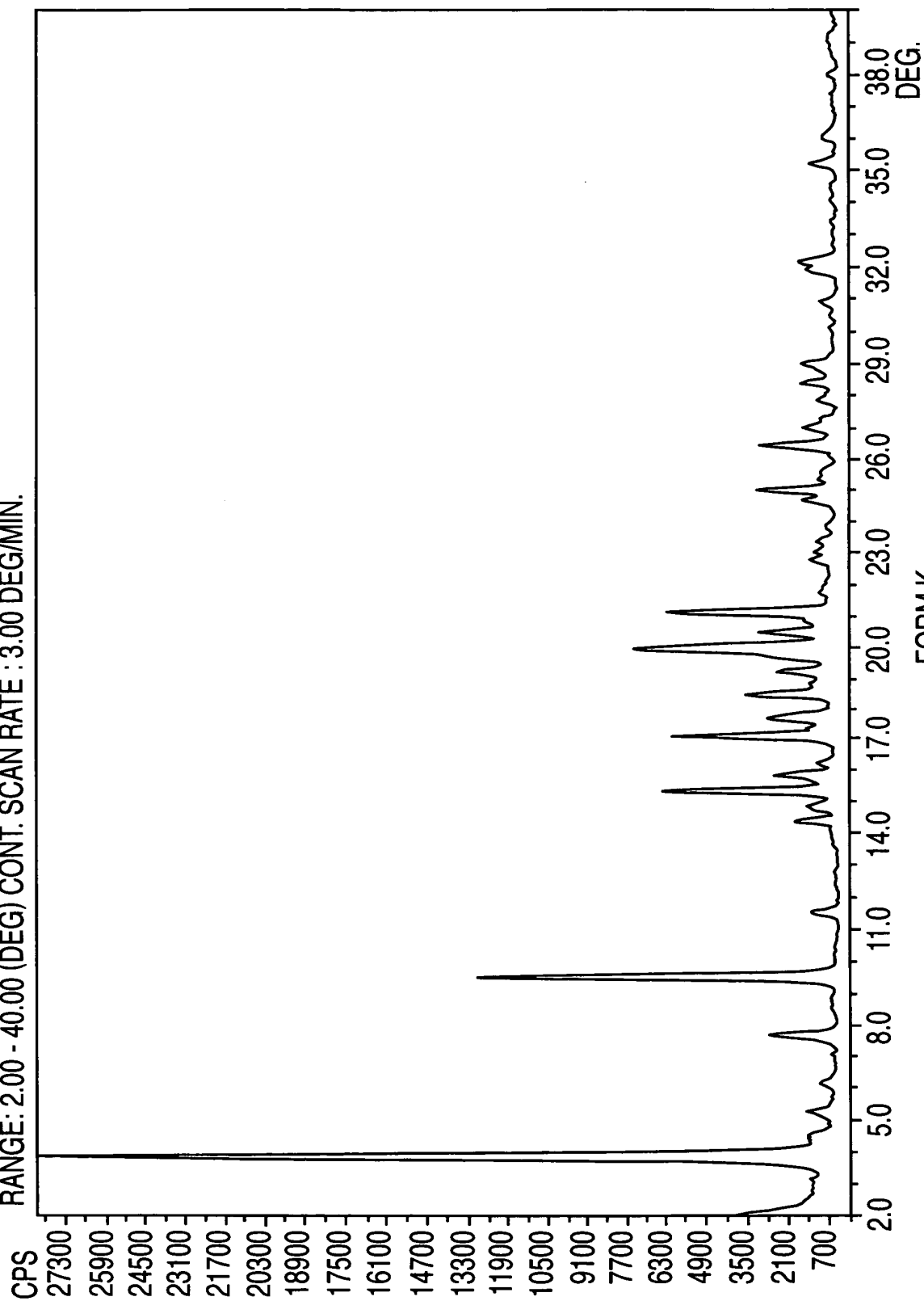


FIG. 8

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.

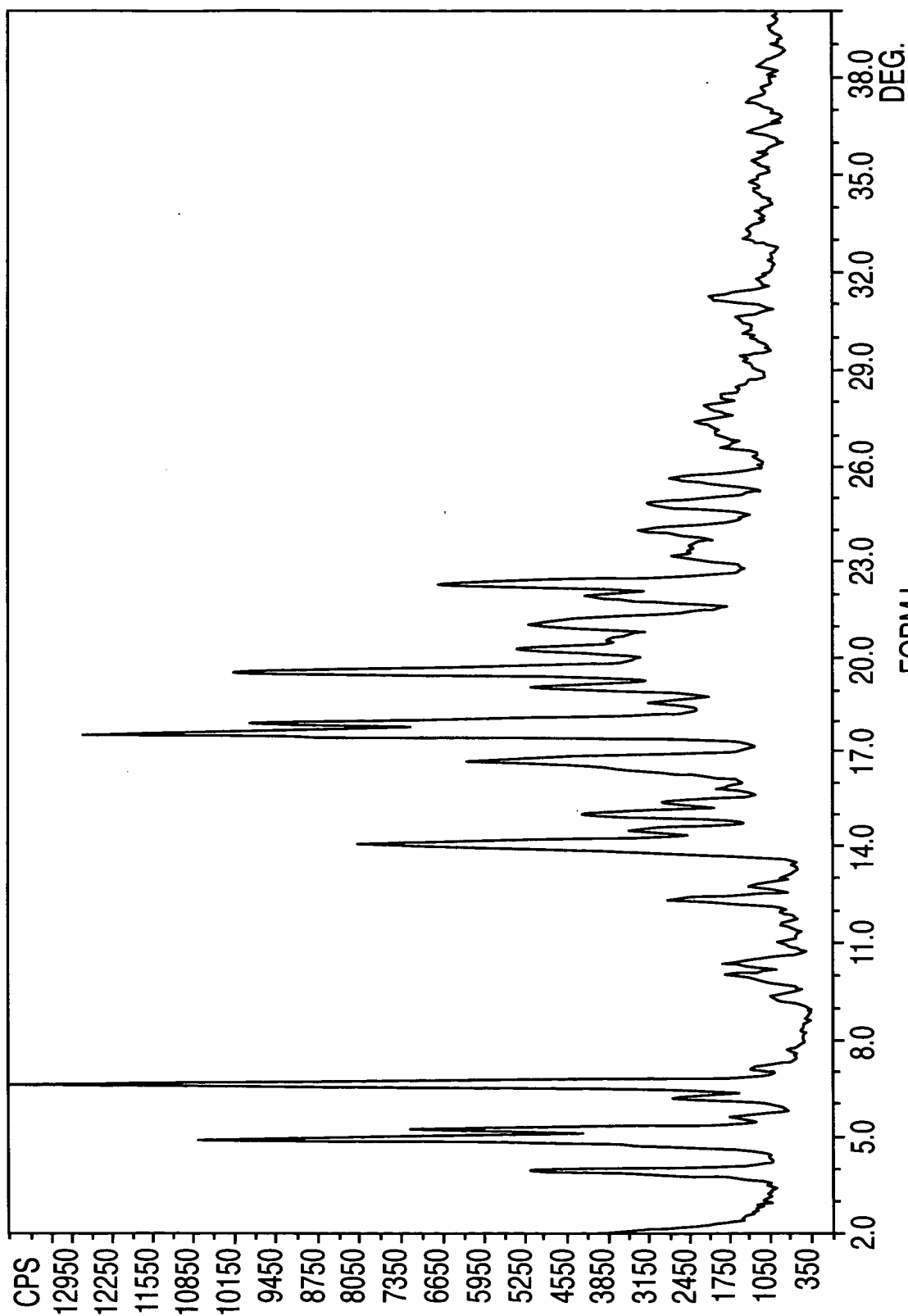


FORM K

FIG. 9

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STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.

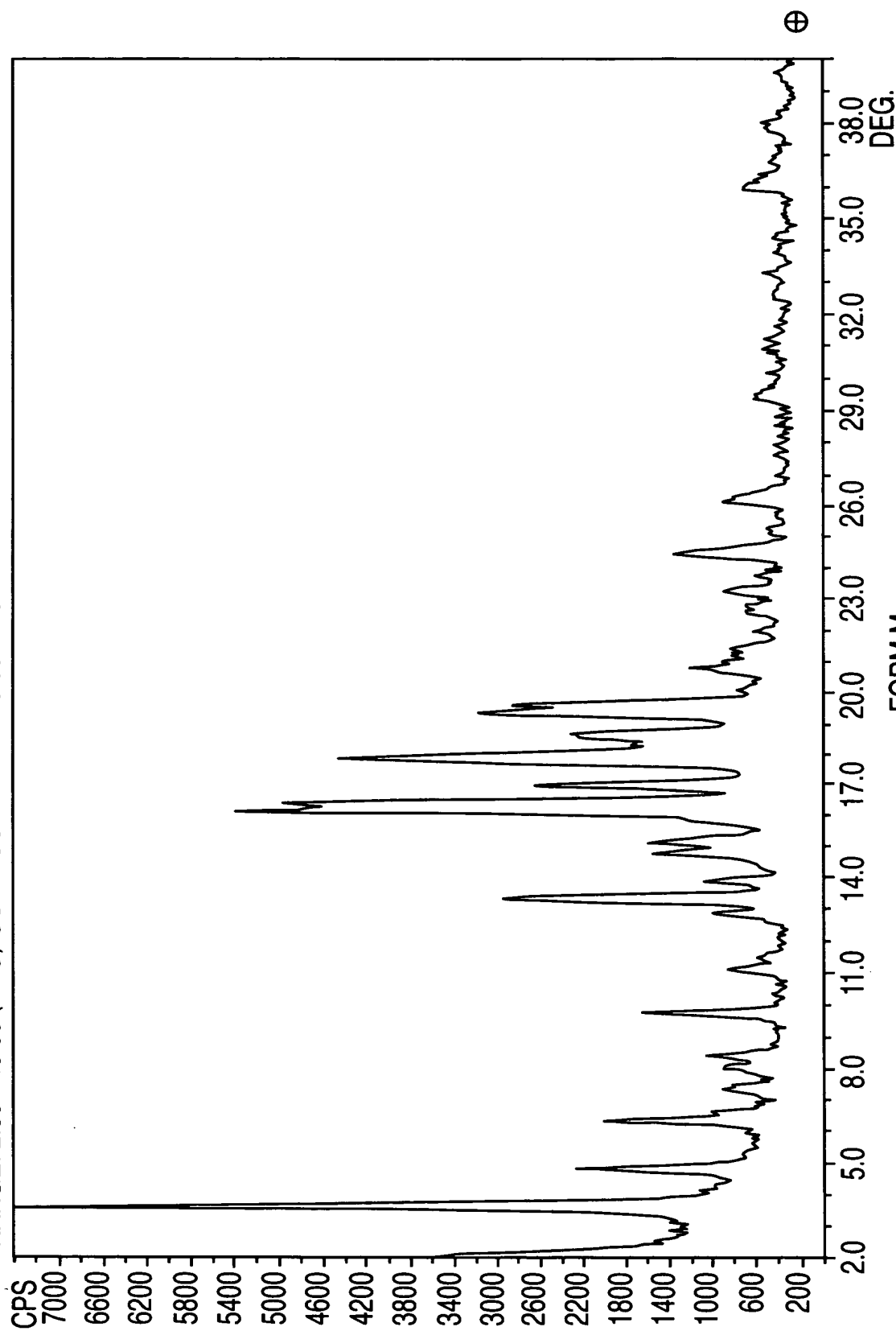


FORM L

FIG. 10

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STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CNT. SCAN RATE : 3.00 DEG/MIN.



FORM M

FIG. 11

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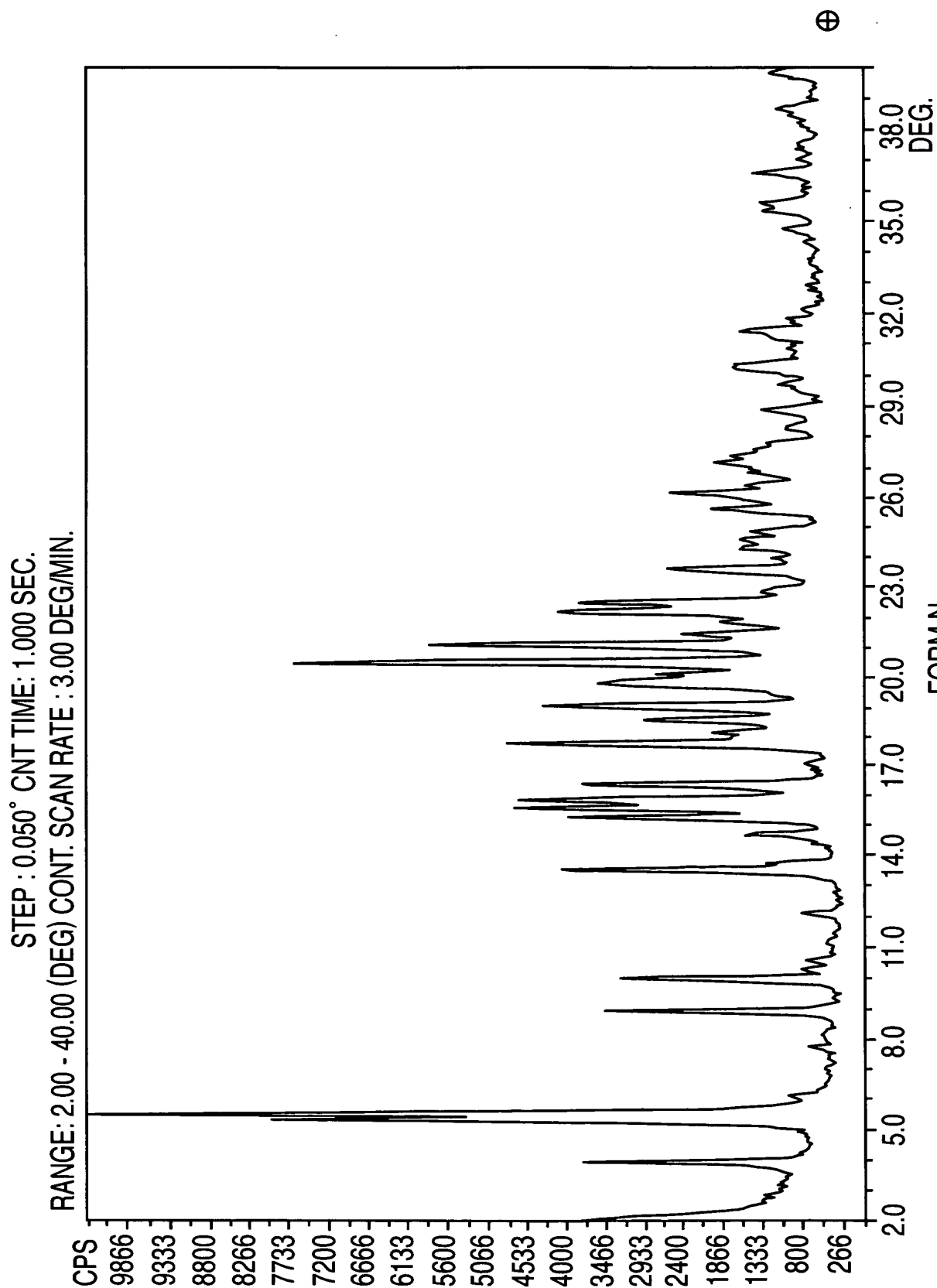


FIG. 12

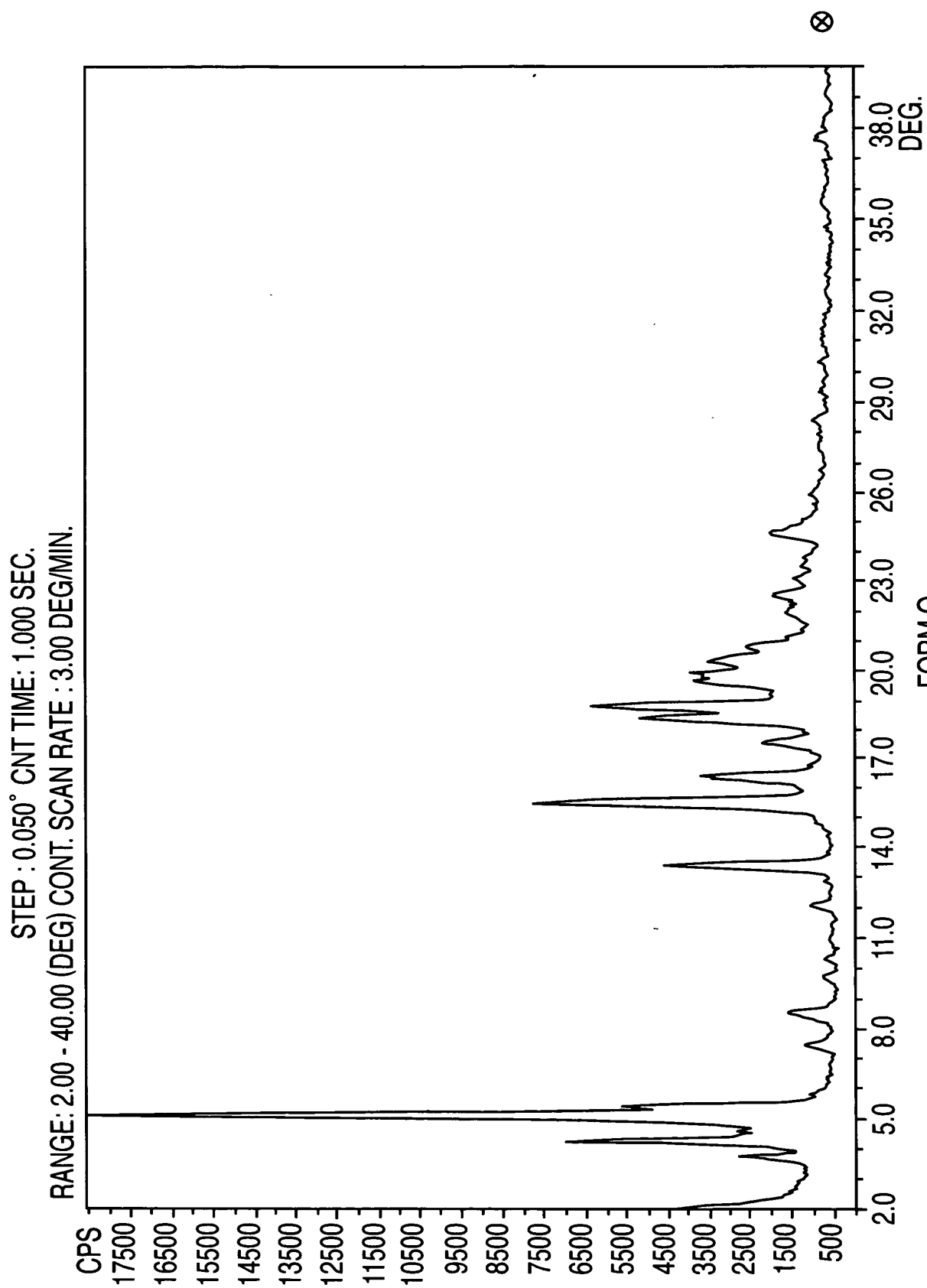
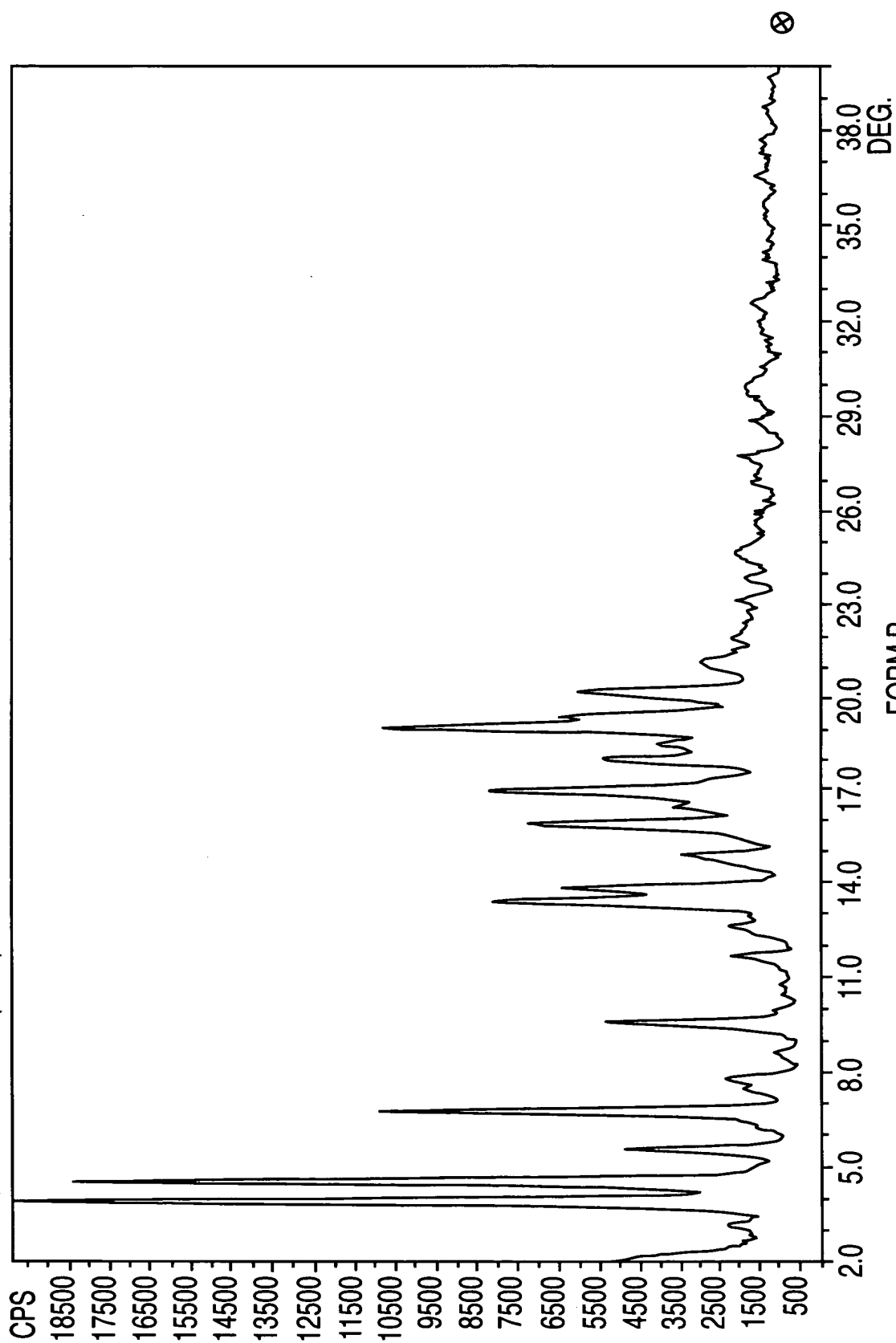


FIG. 13

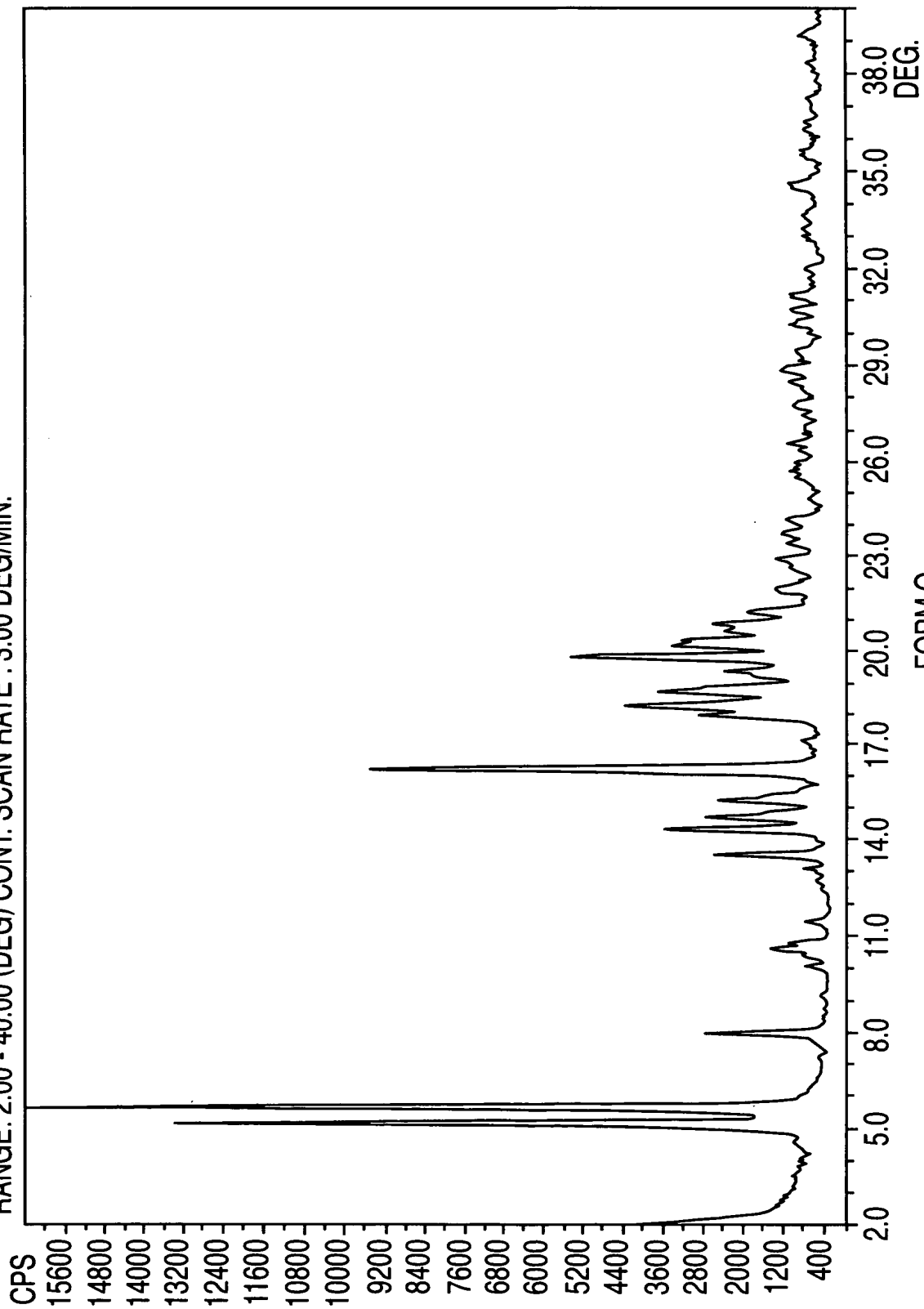
STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



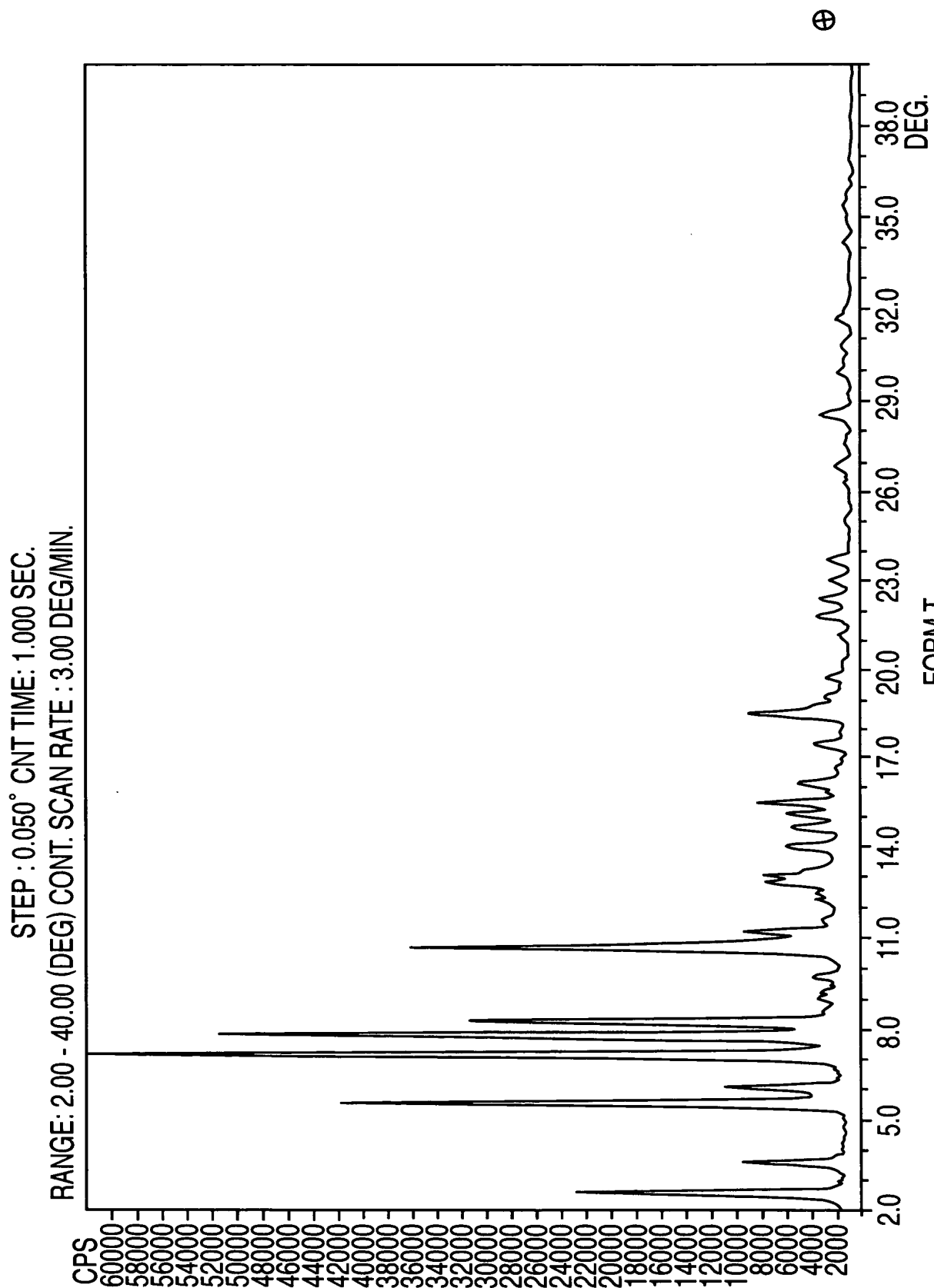
FORM P

FIG. 14

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM Q
FIG. 15

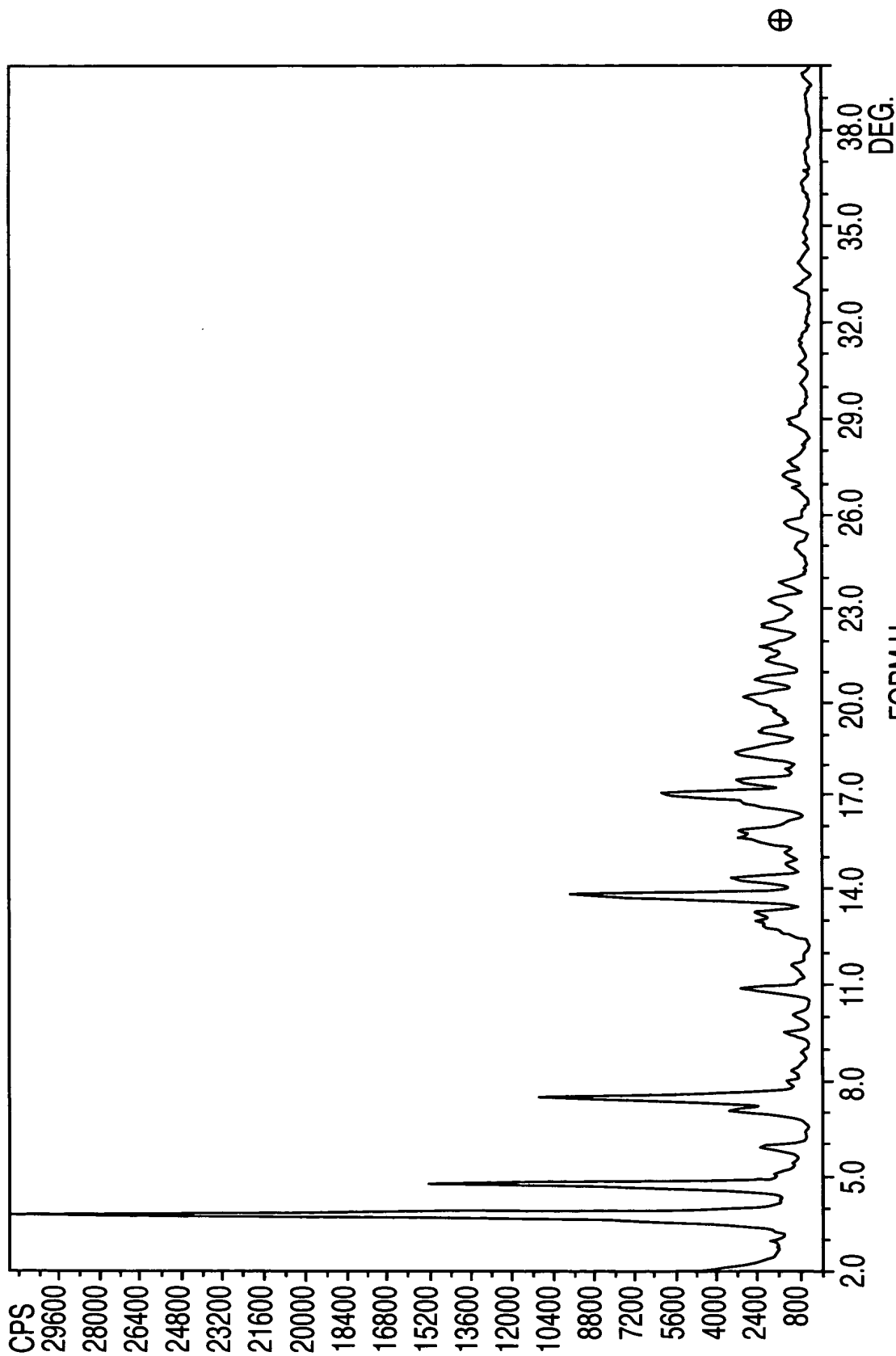


FORM T

FIG. 16

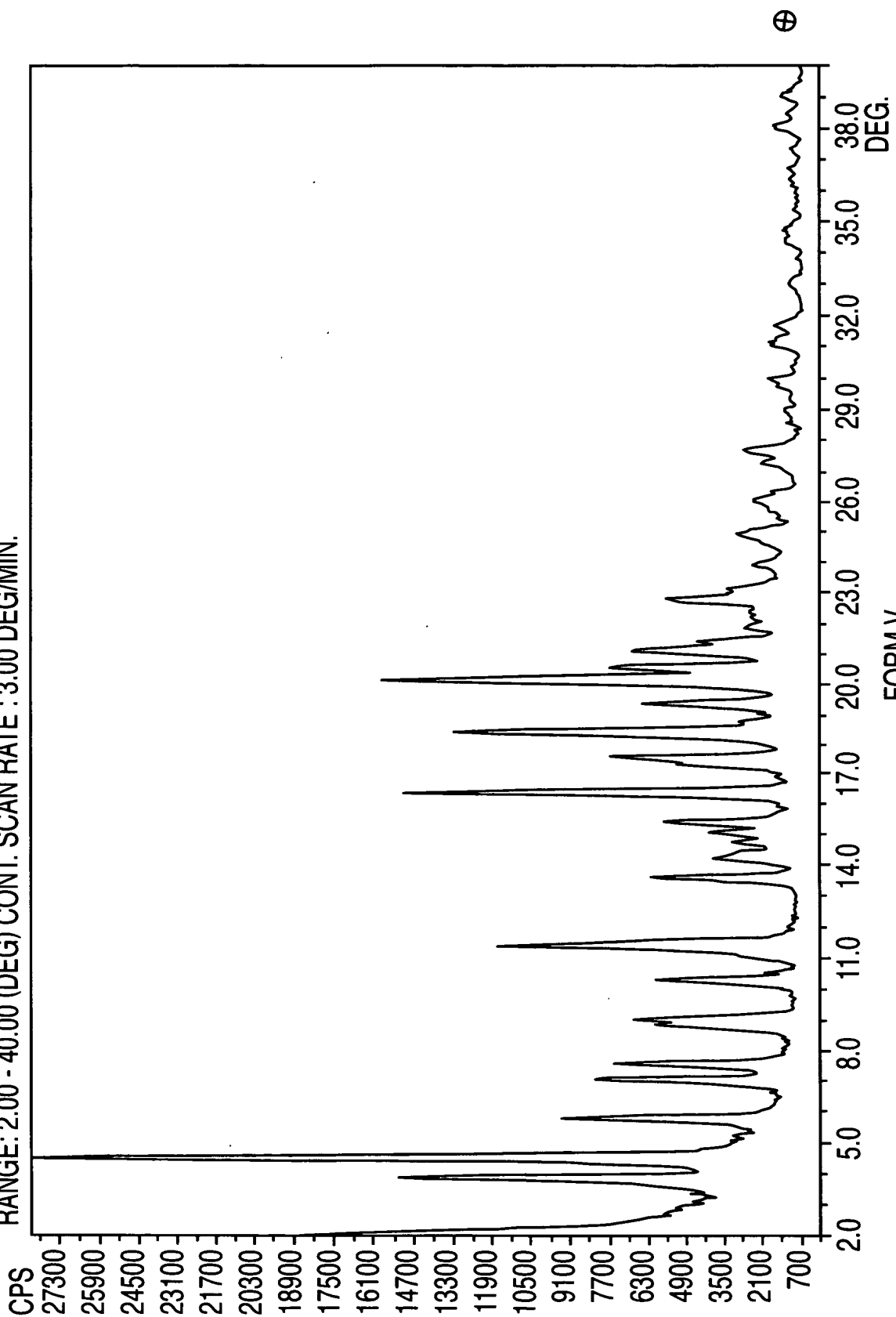
17/64

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM U
FIG. 17

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM V
FIG. 18

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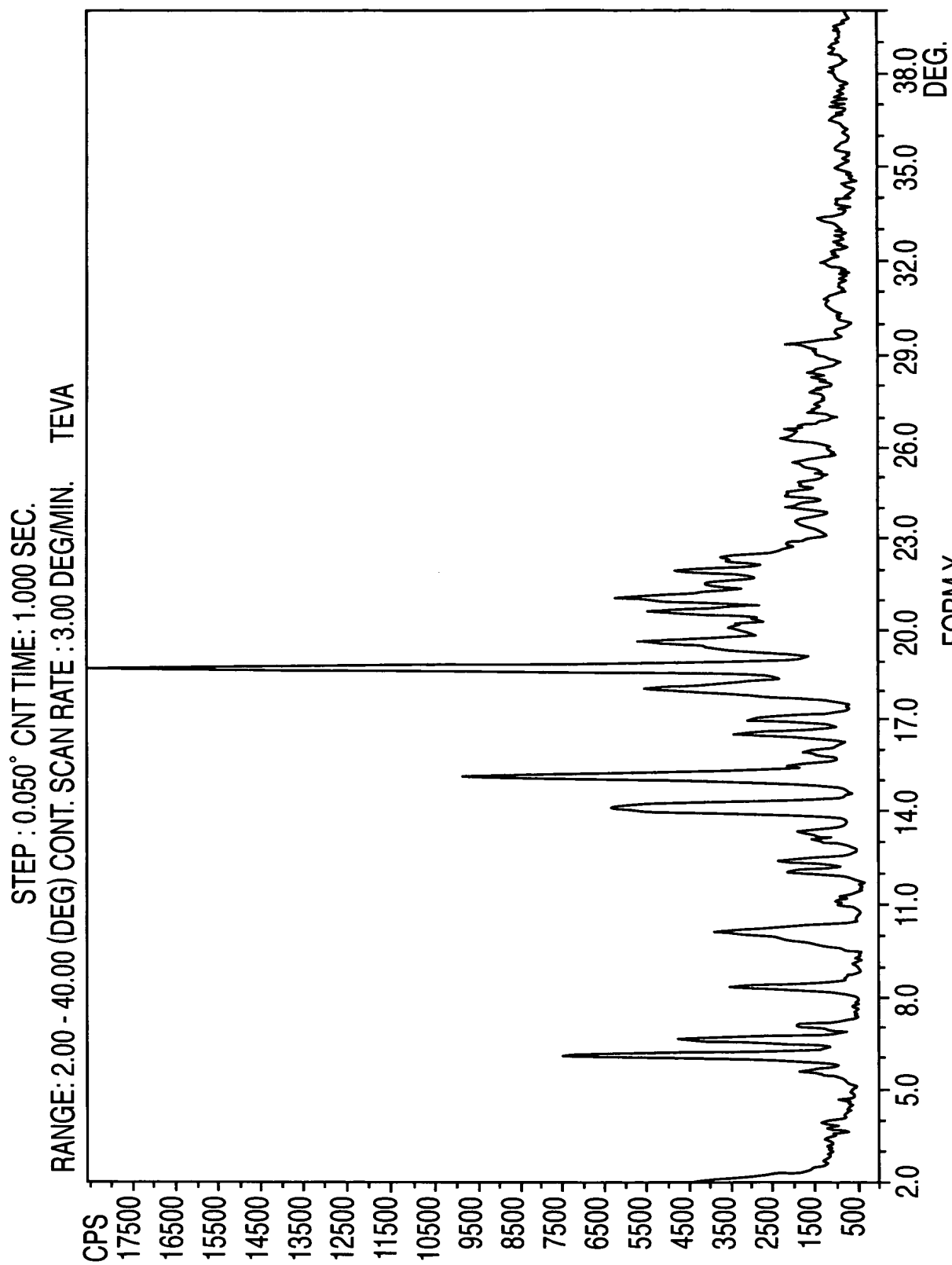


FIG. 19

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.

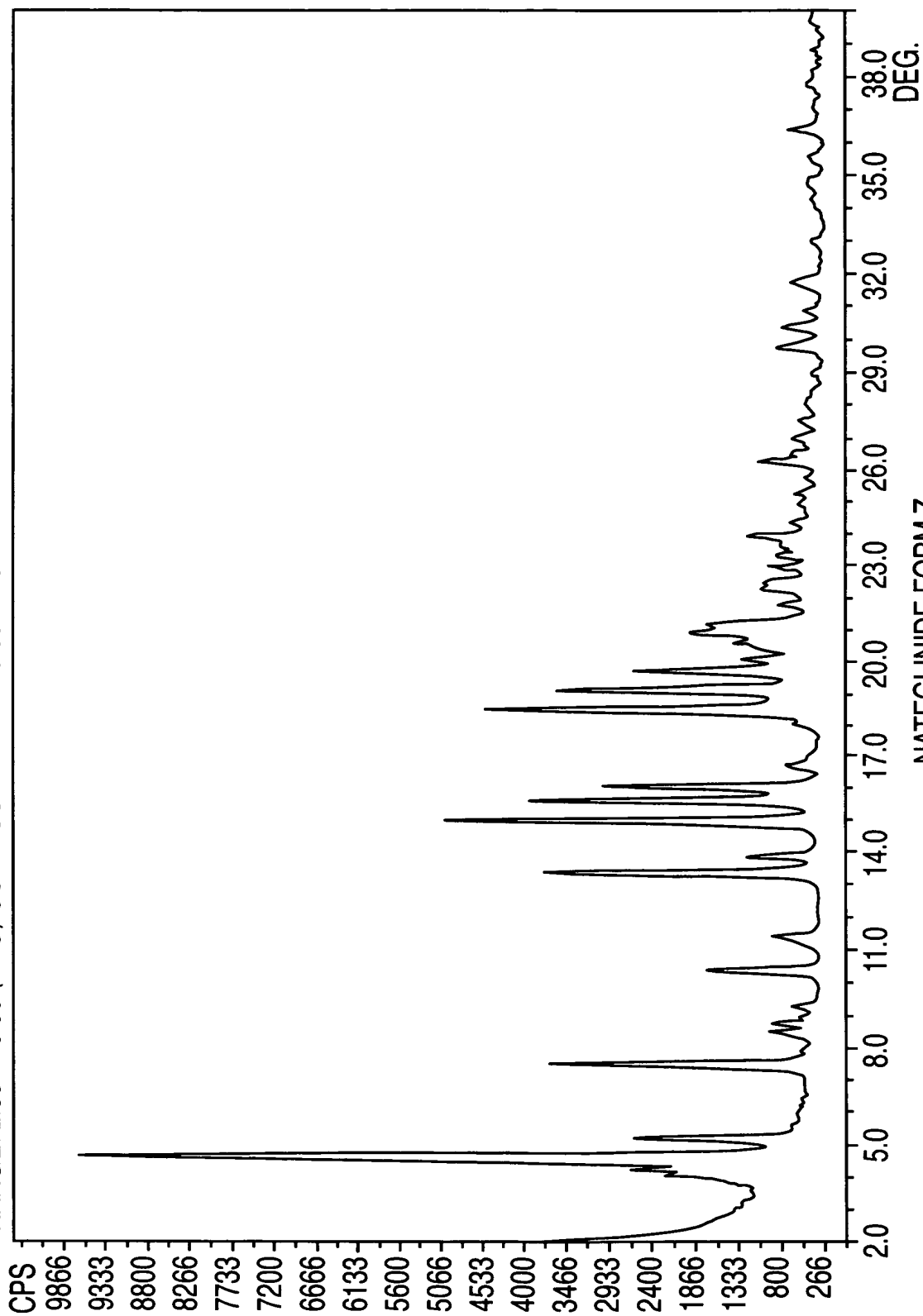


FIG. 20

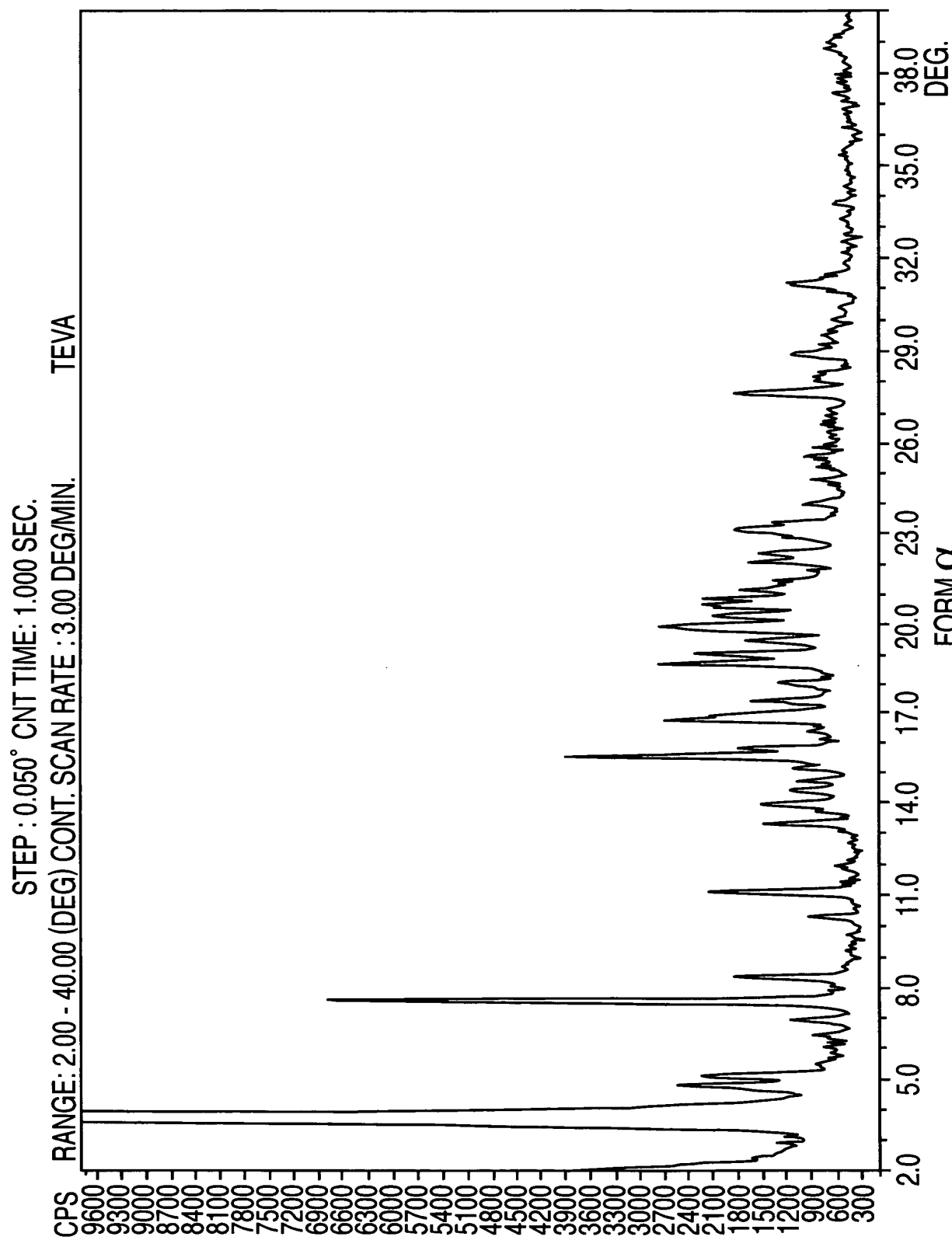
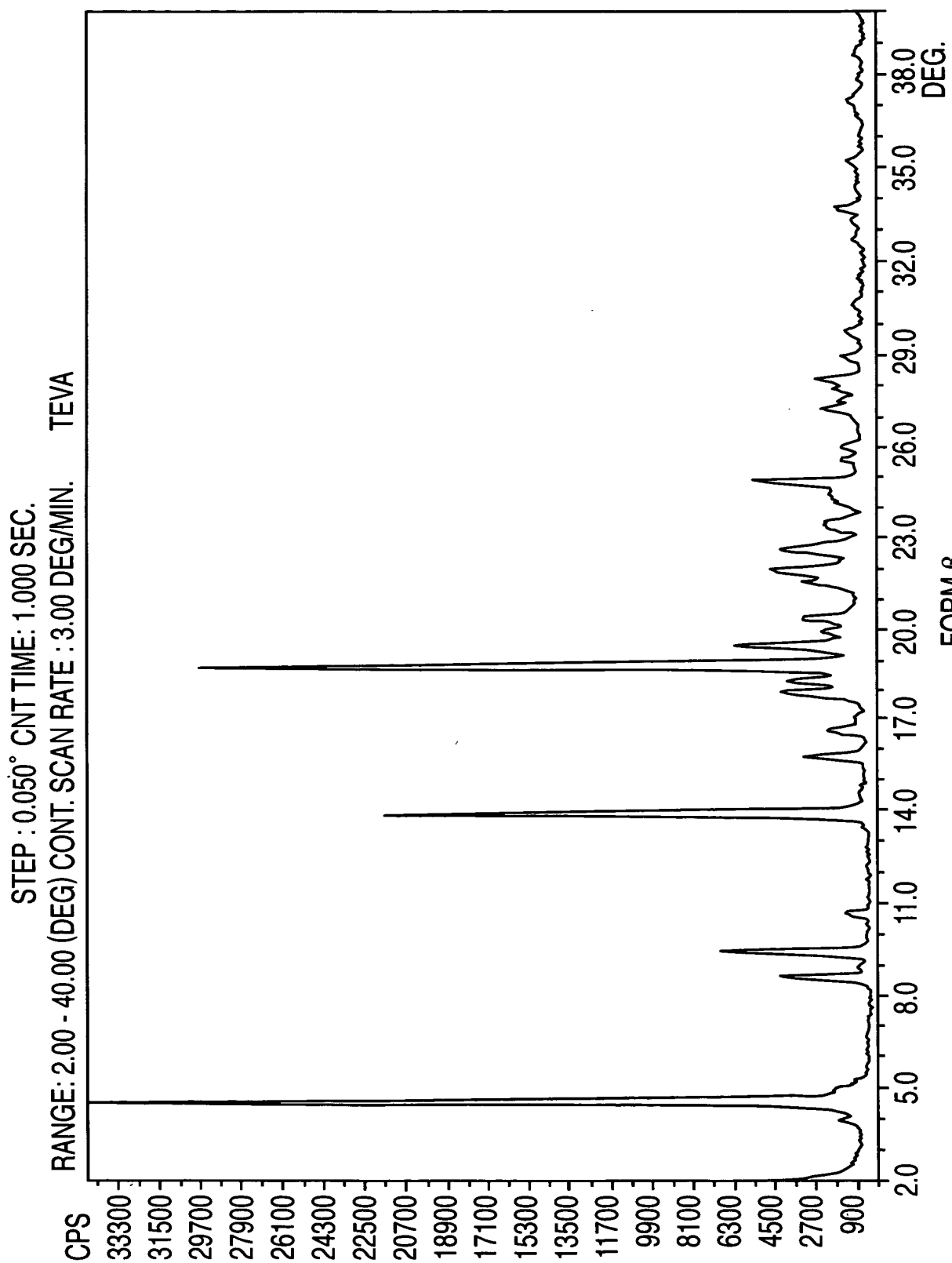
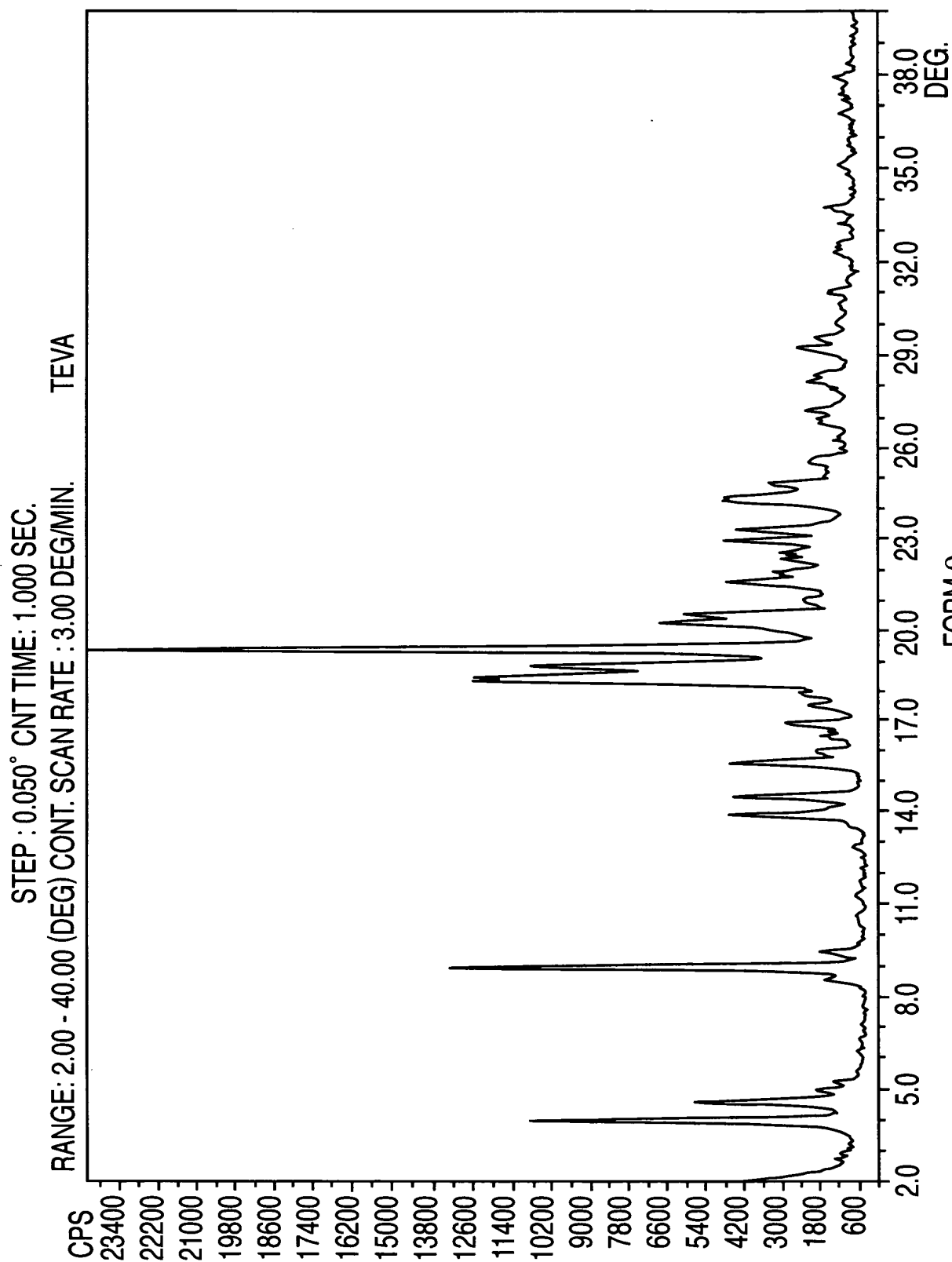


FIG. 21

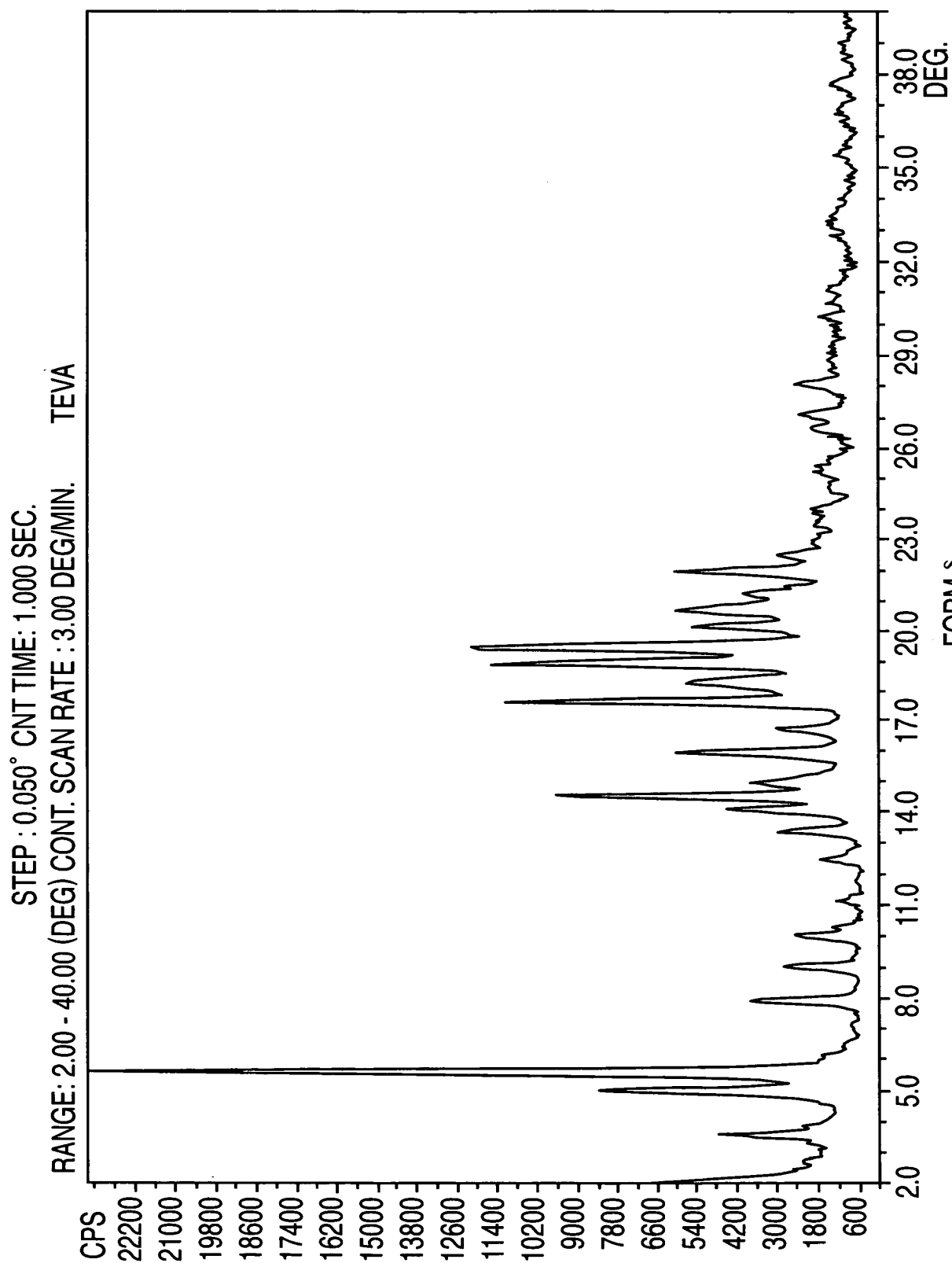


FORM β
FIG. 22



FORM P

FIG. 23



FORM 8

FIG. 24

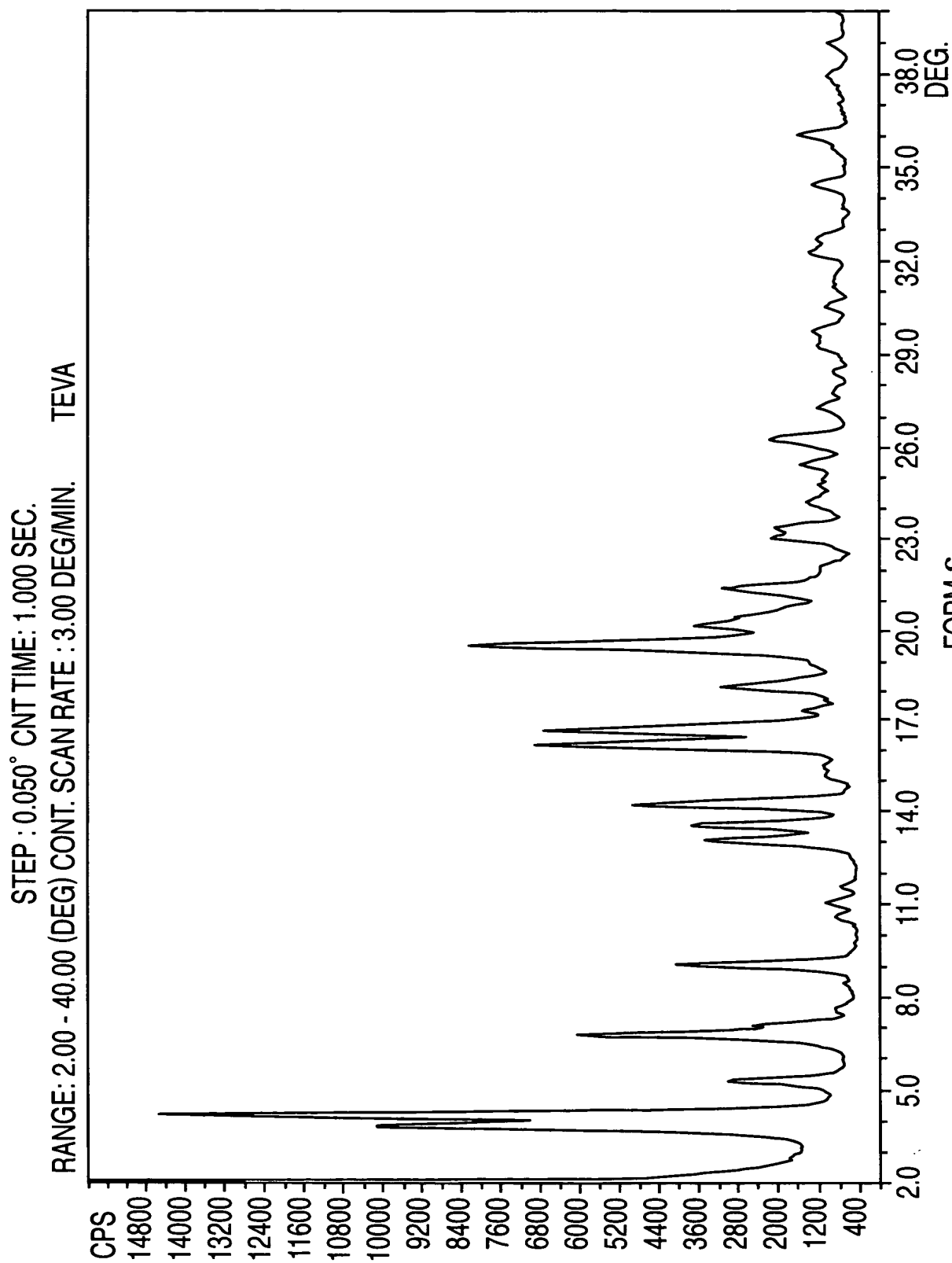
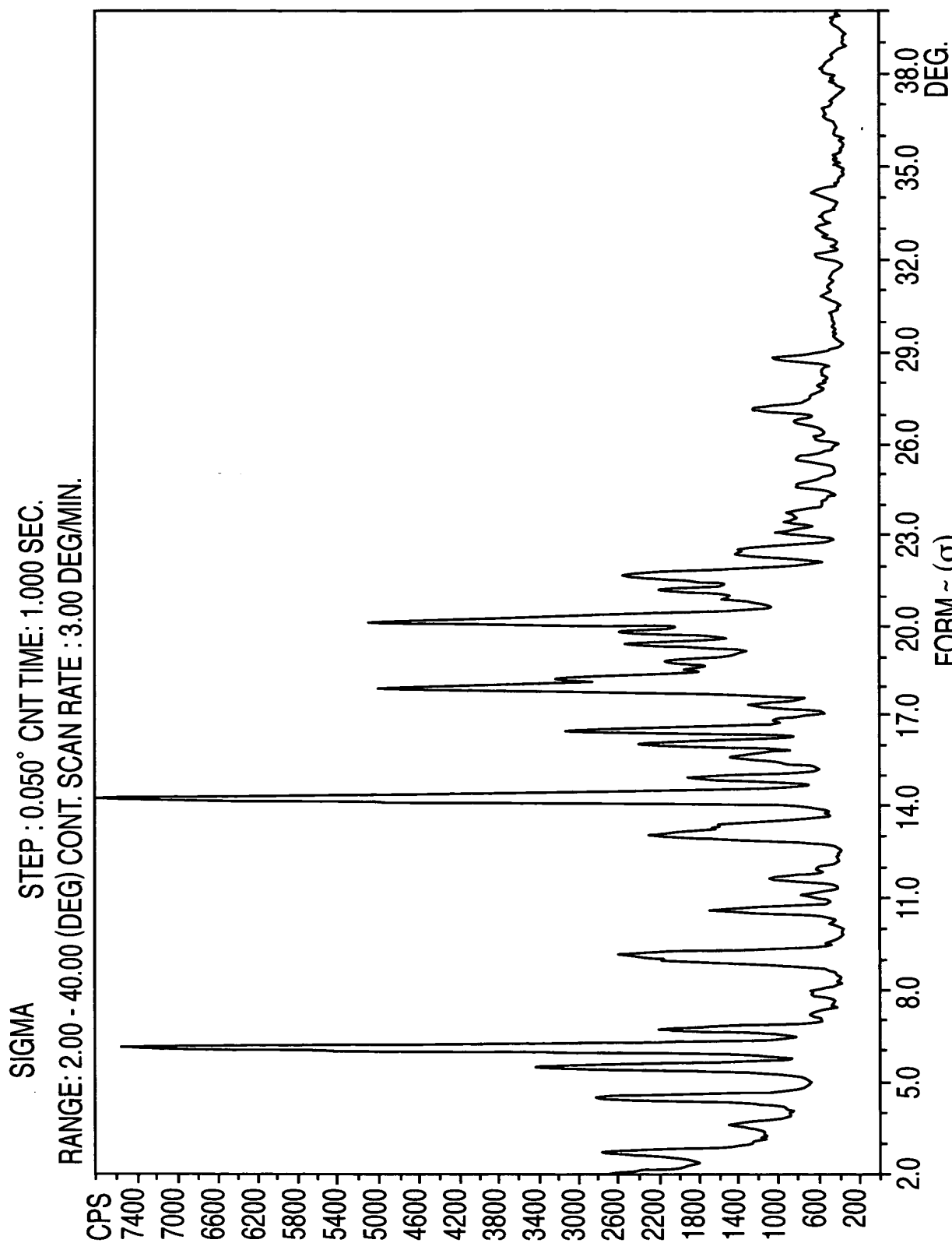
FORM ϵ

FIG. 25



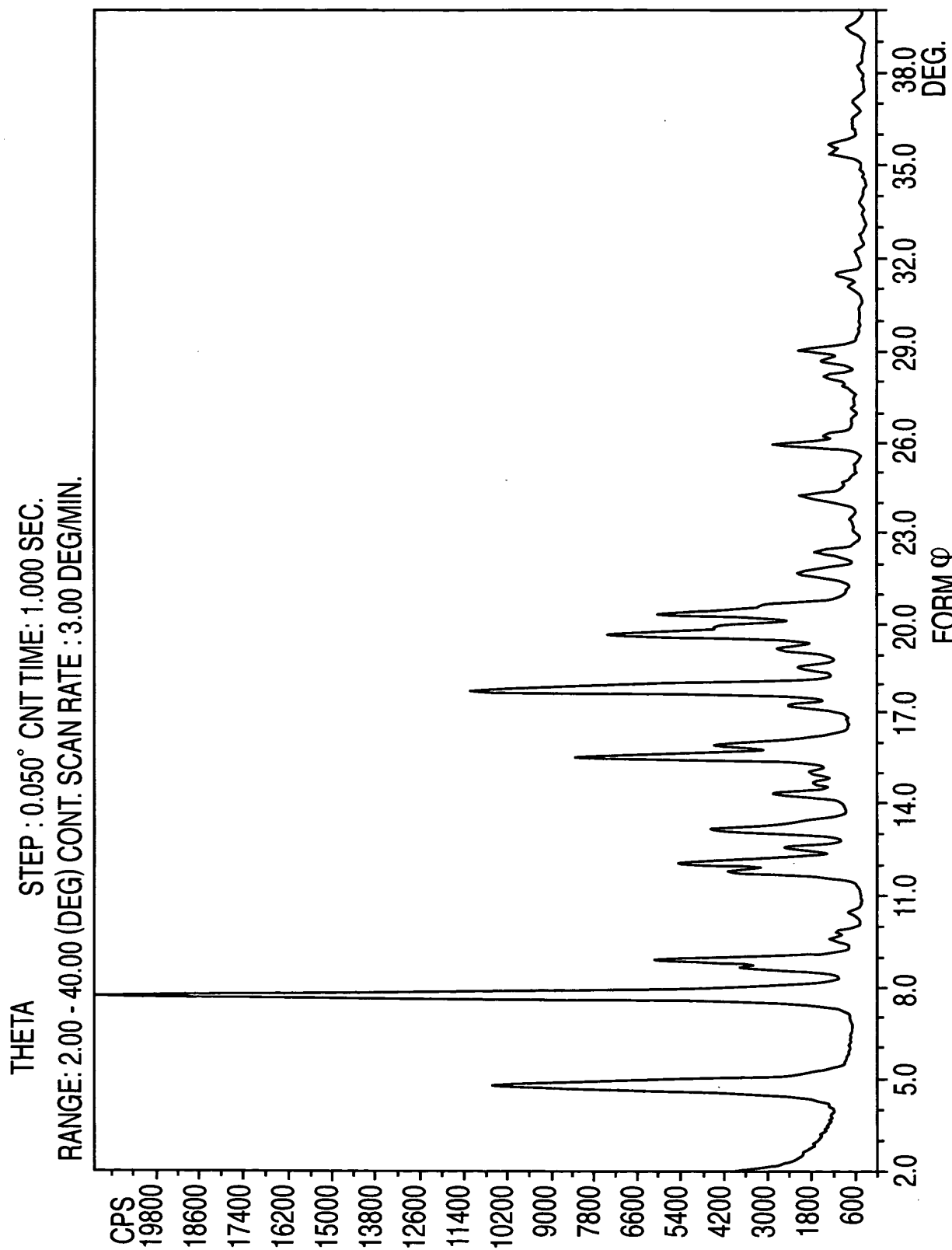
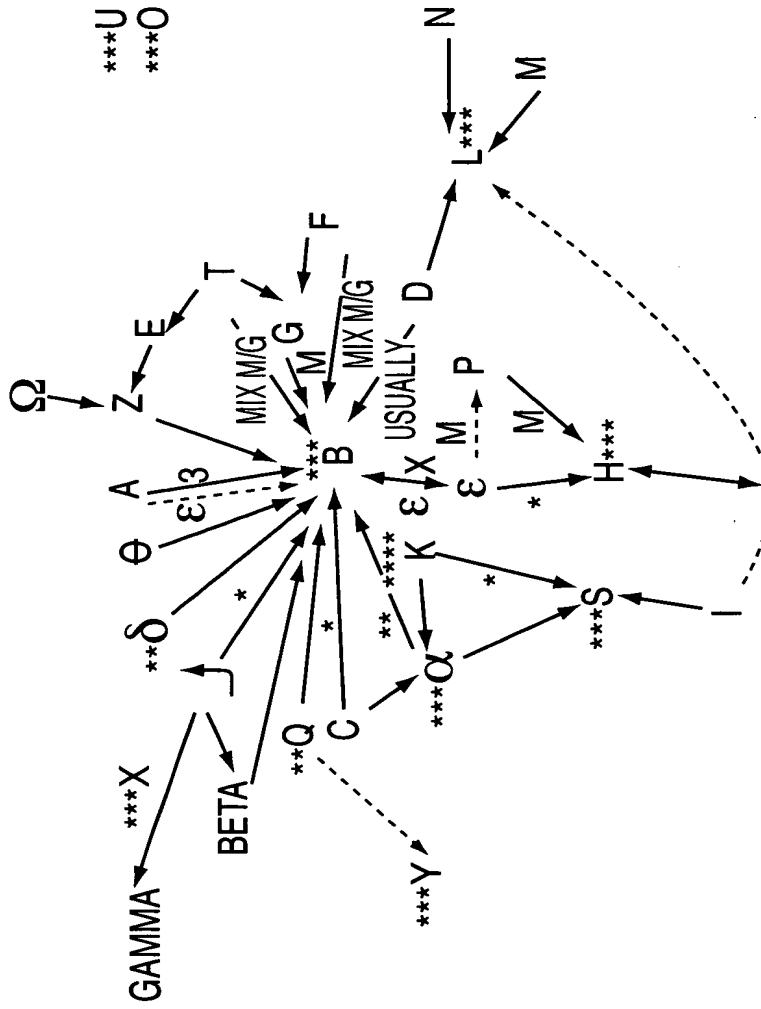


FIG. 27

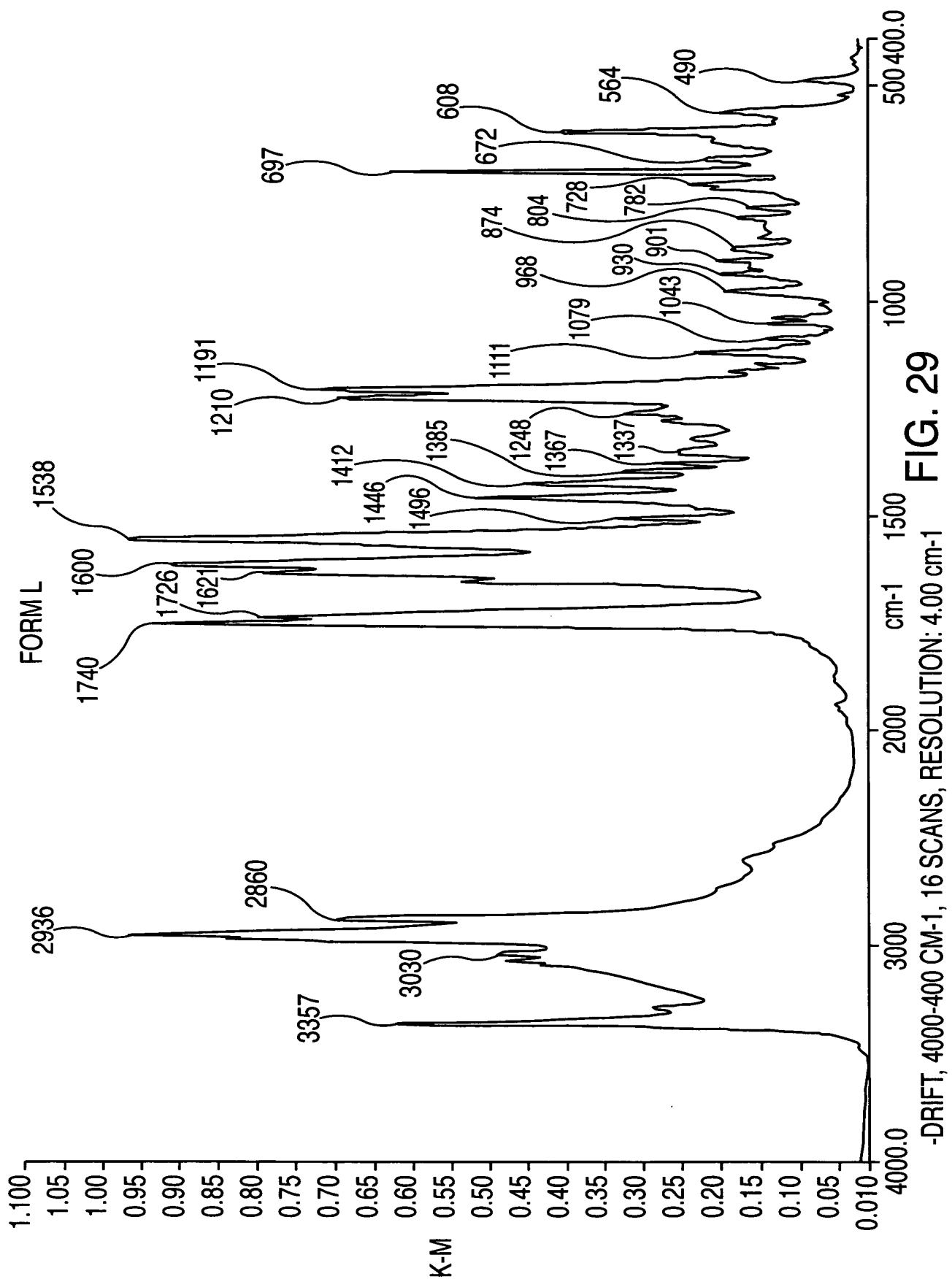


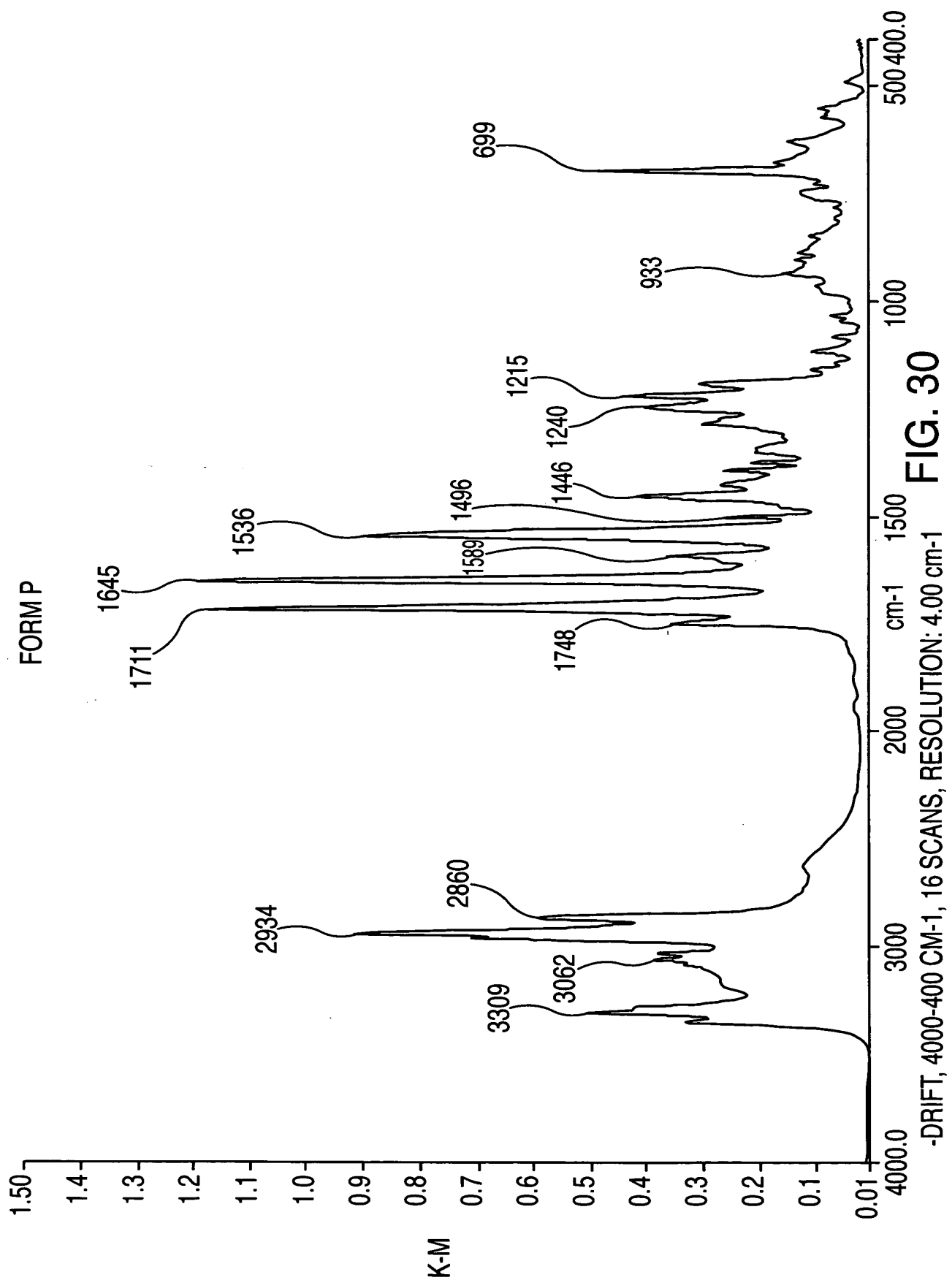
- * TRANSFORMATION MAY PROCEED THROUGH ANOTHER TERM.
- ** THERMALLY STABLE AT LOWER HEATING TEMPERATURES (~50°C).
- *** THERMALLY STABLE FORMS.
- TRANSFORMATION AFTER STORAGE AT ROOM TEMPERATURE.
- m MIXTURE WITH STARTING FORM.
- **** WHEN STARTING MATERIAL CONTAINS SEEDS.
- sol RESULTS MIGHT VARY DEPENDING ON THE SOLVATE OF FORM EPSILON USED.

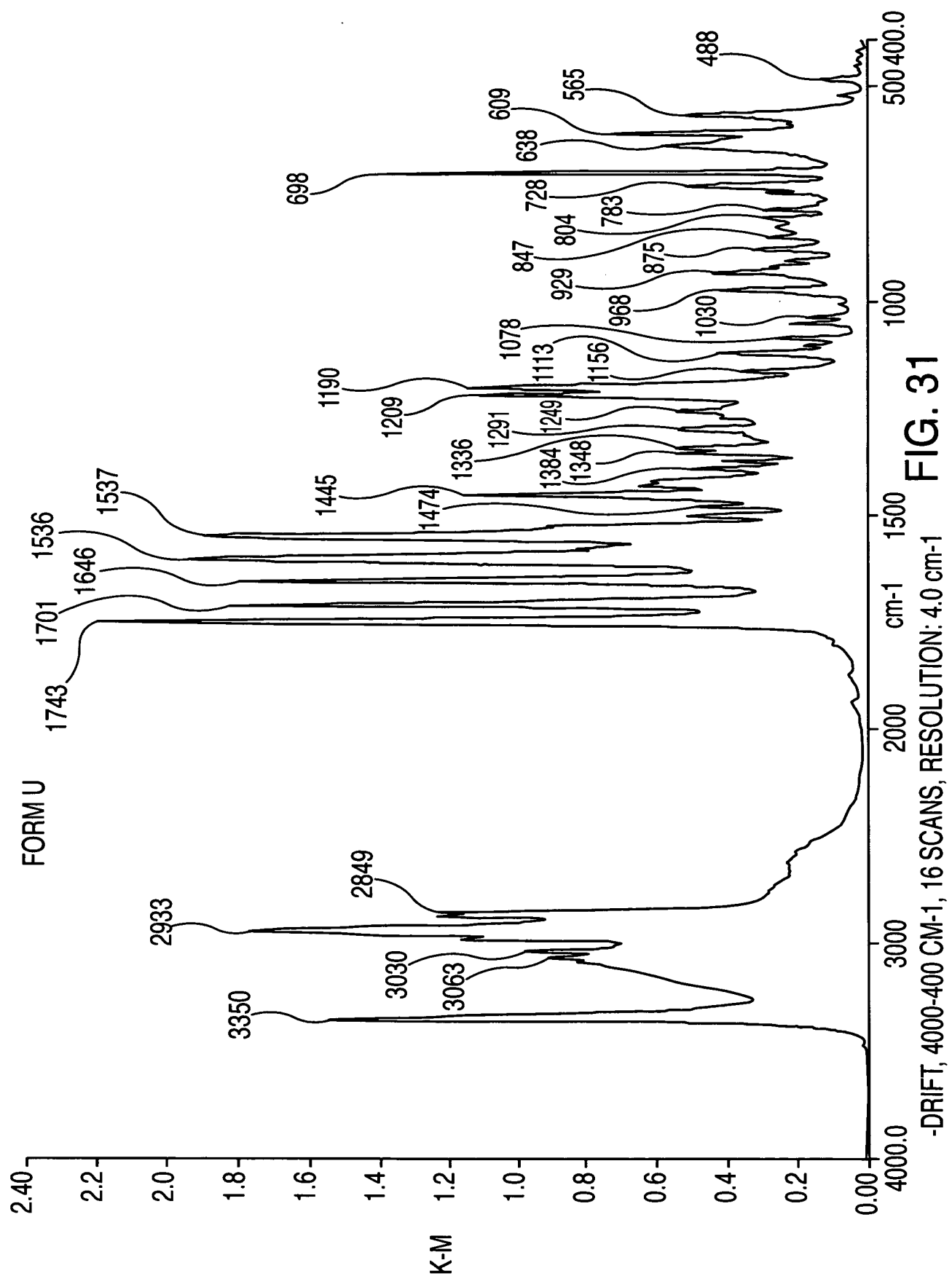
THERMAL STABILITY CHART

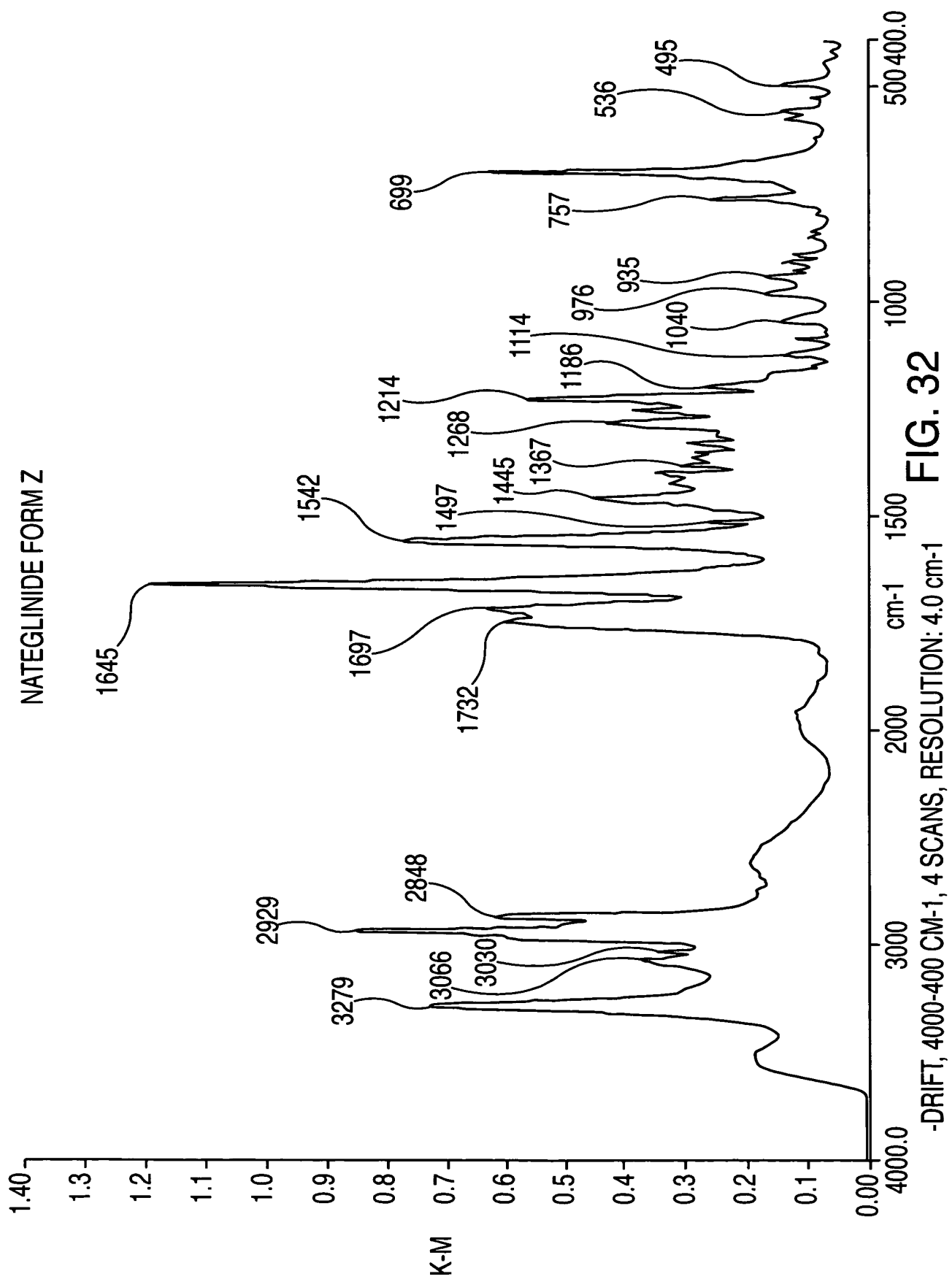
FIG. 28

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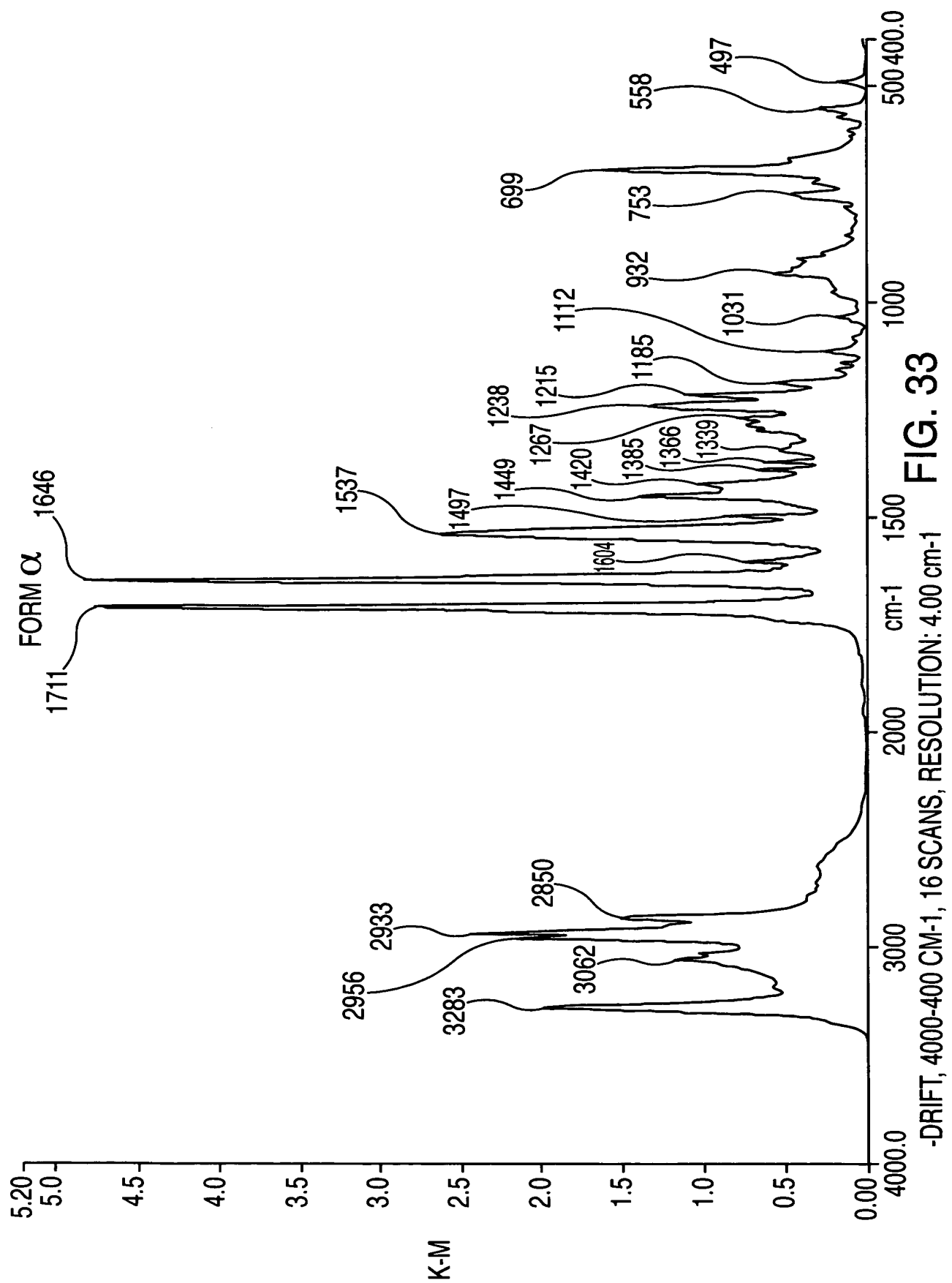
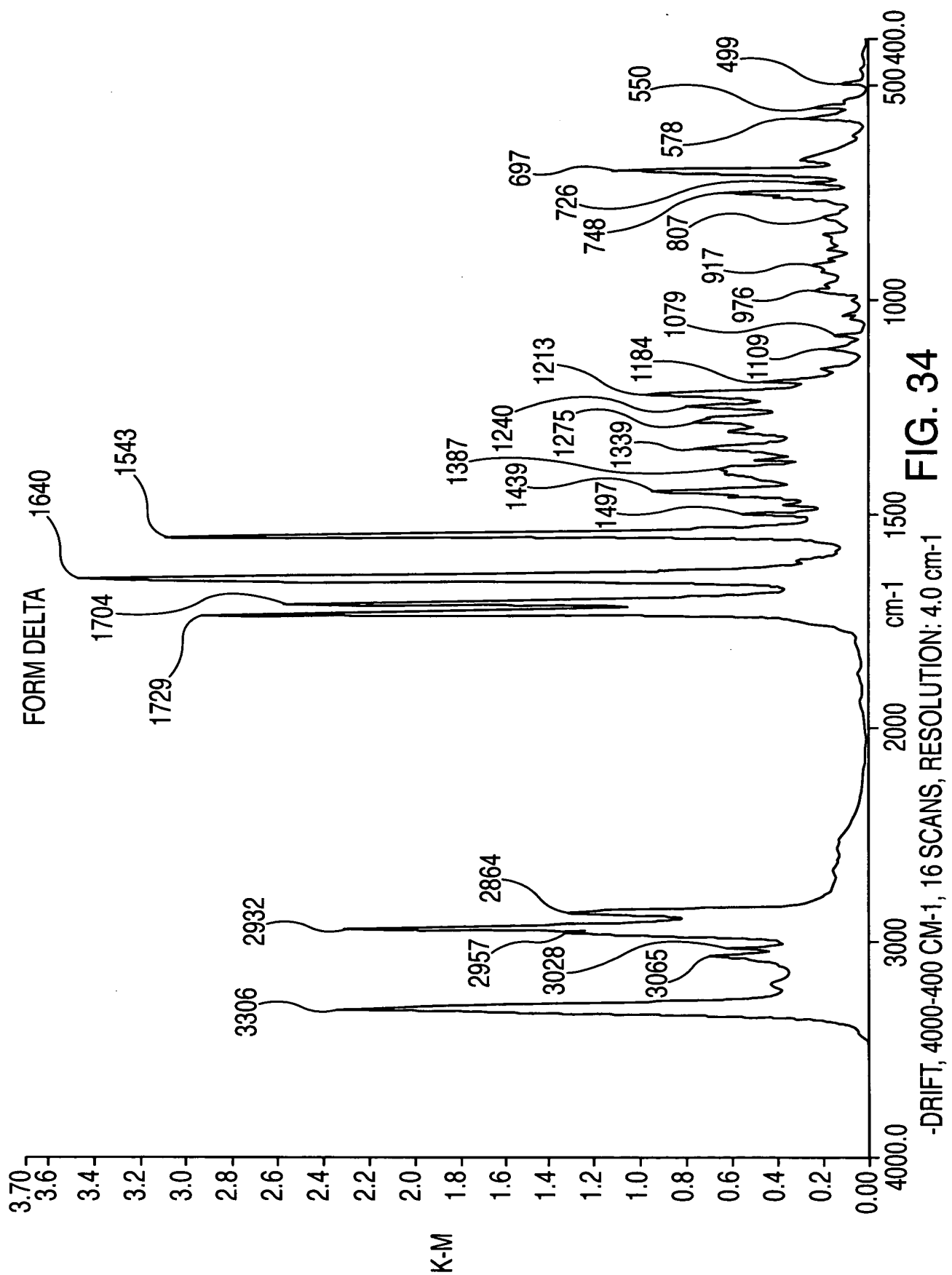


FIG. 33

-DRIFT, 4000-400 CM-1, 16 SCANS, RESOLUTION: 4.00 CM-1



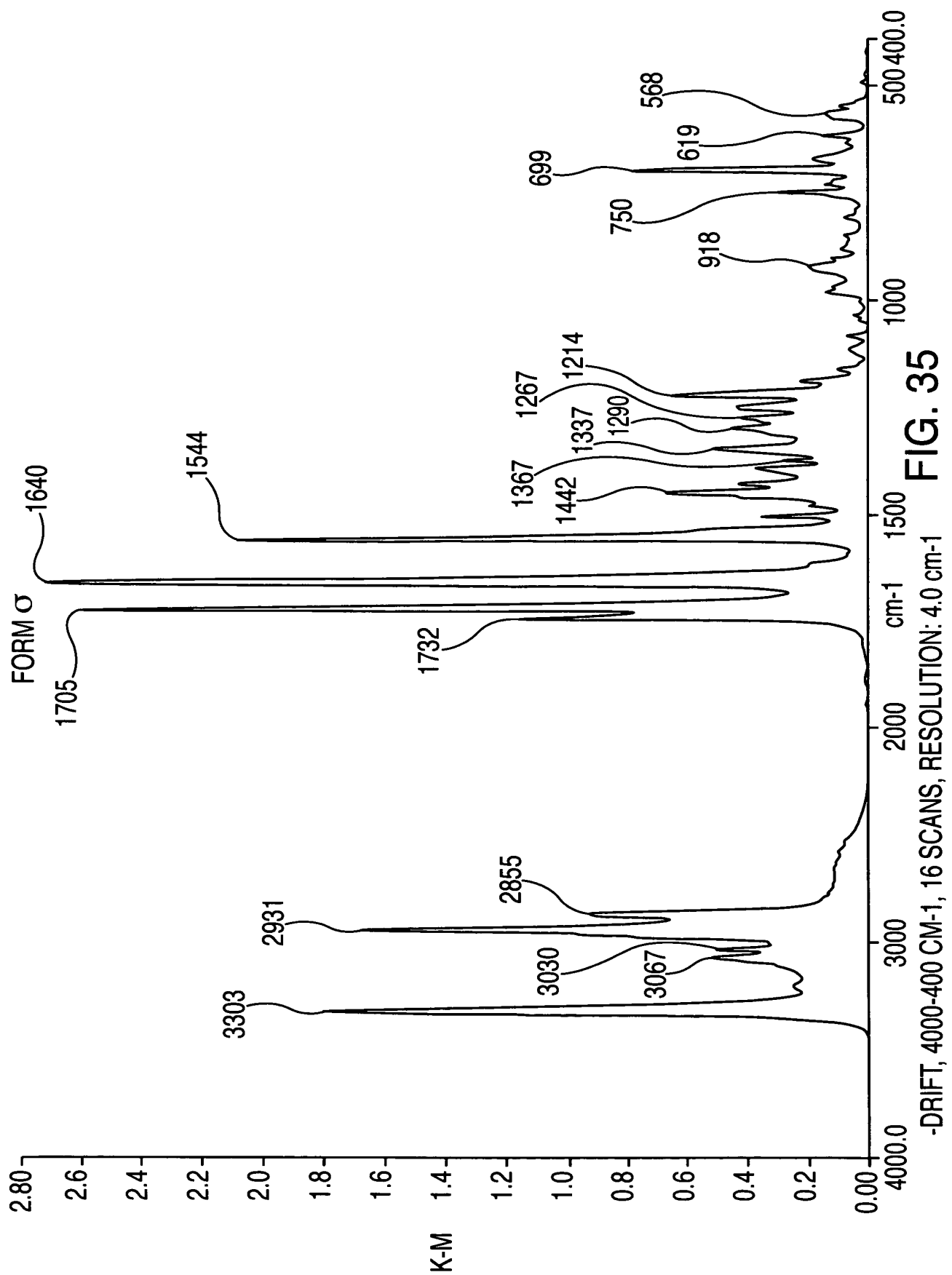
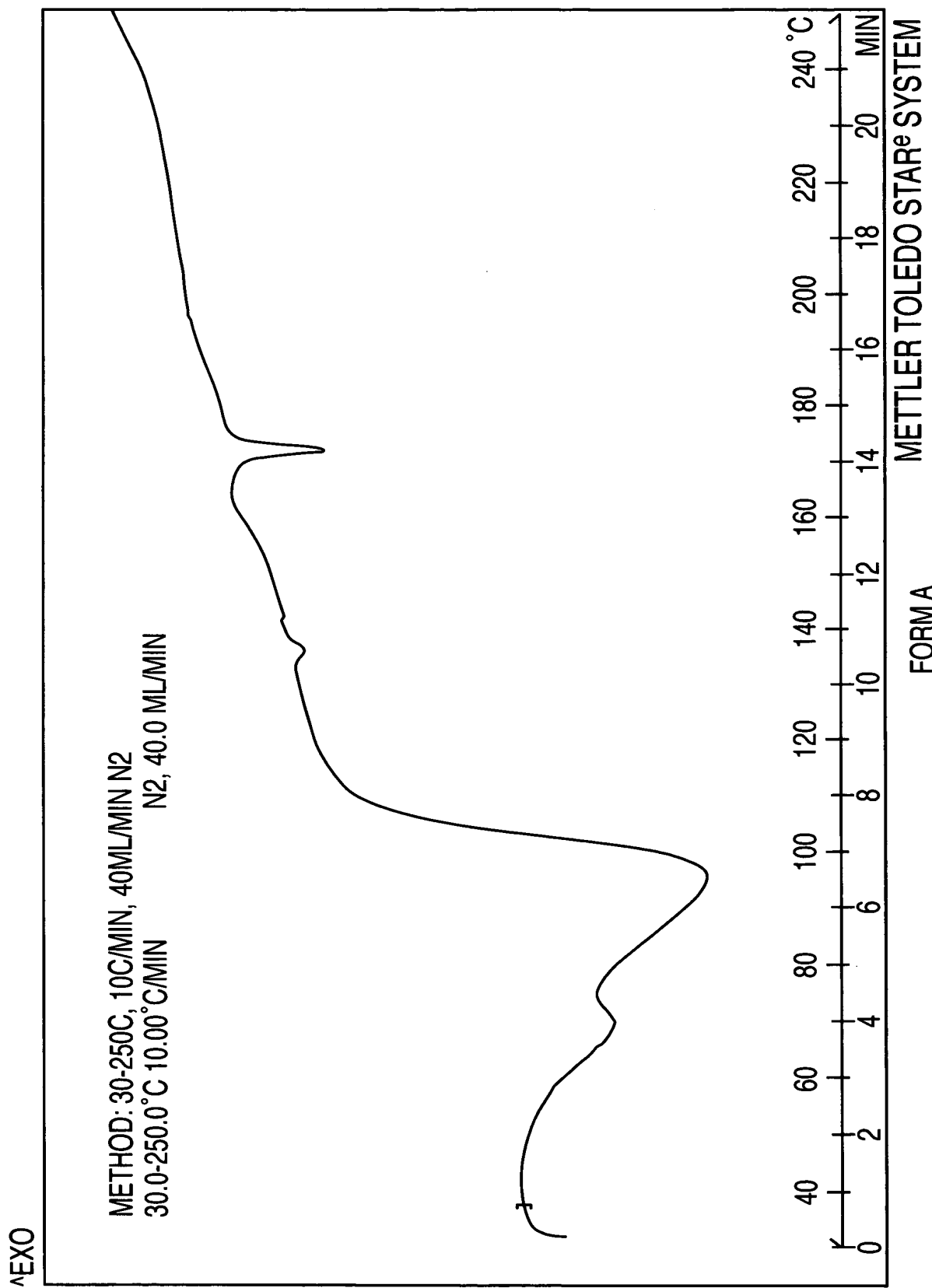
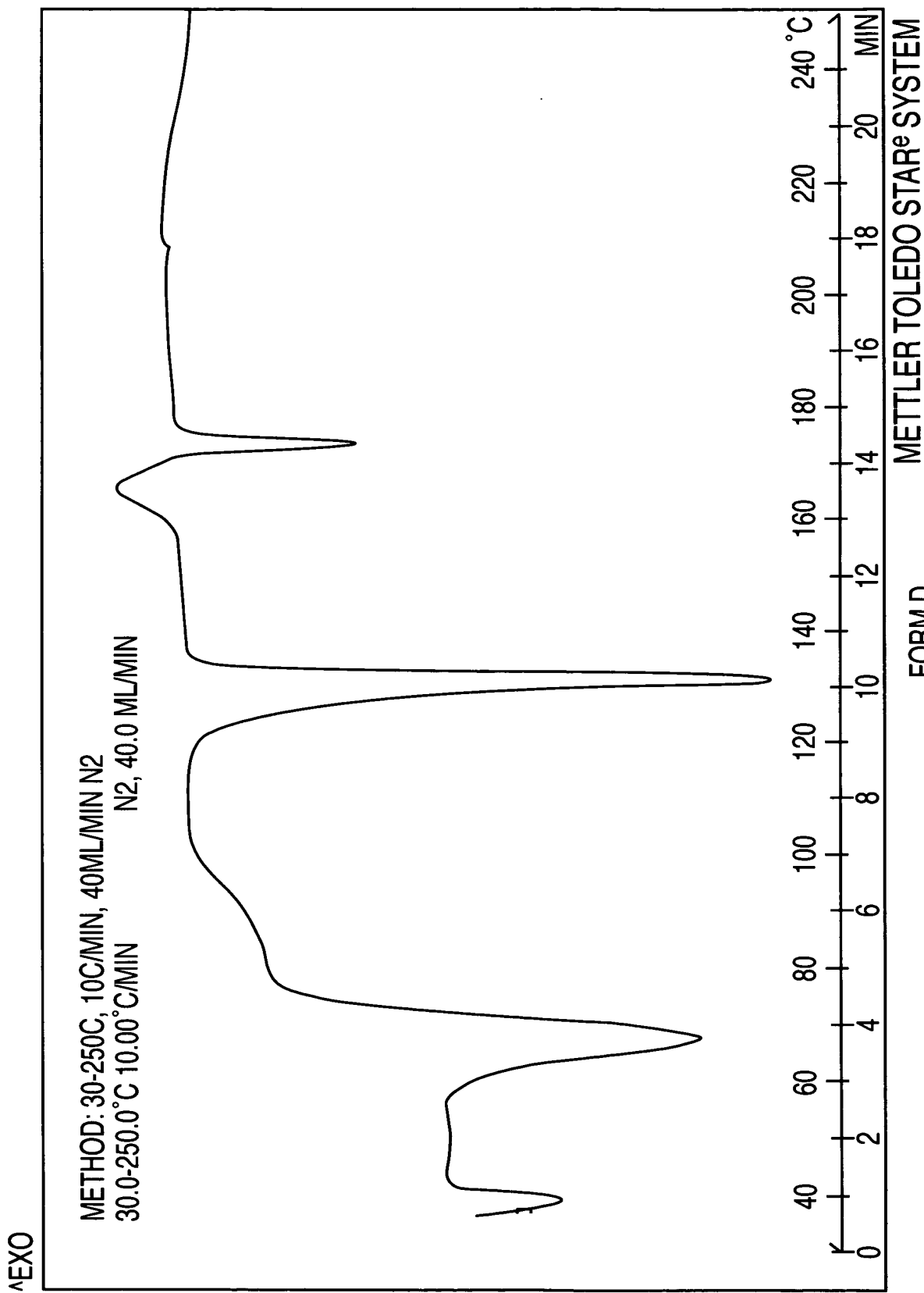


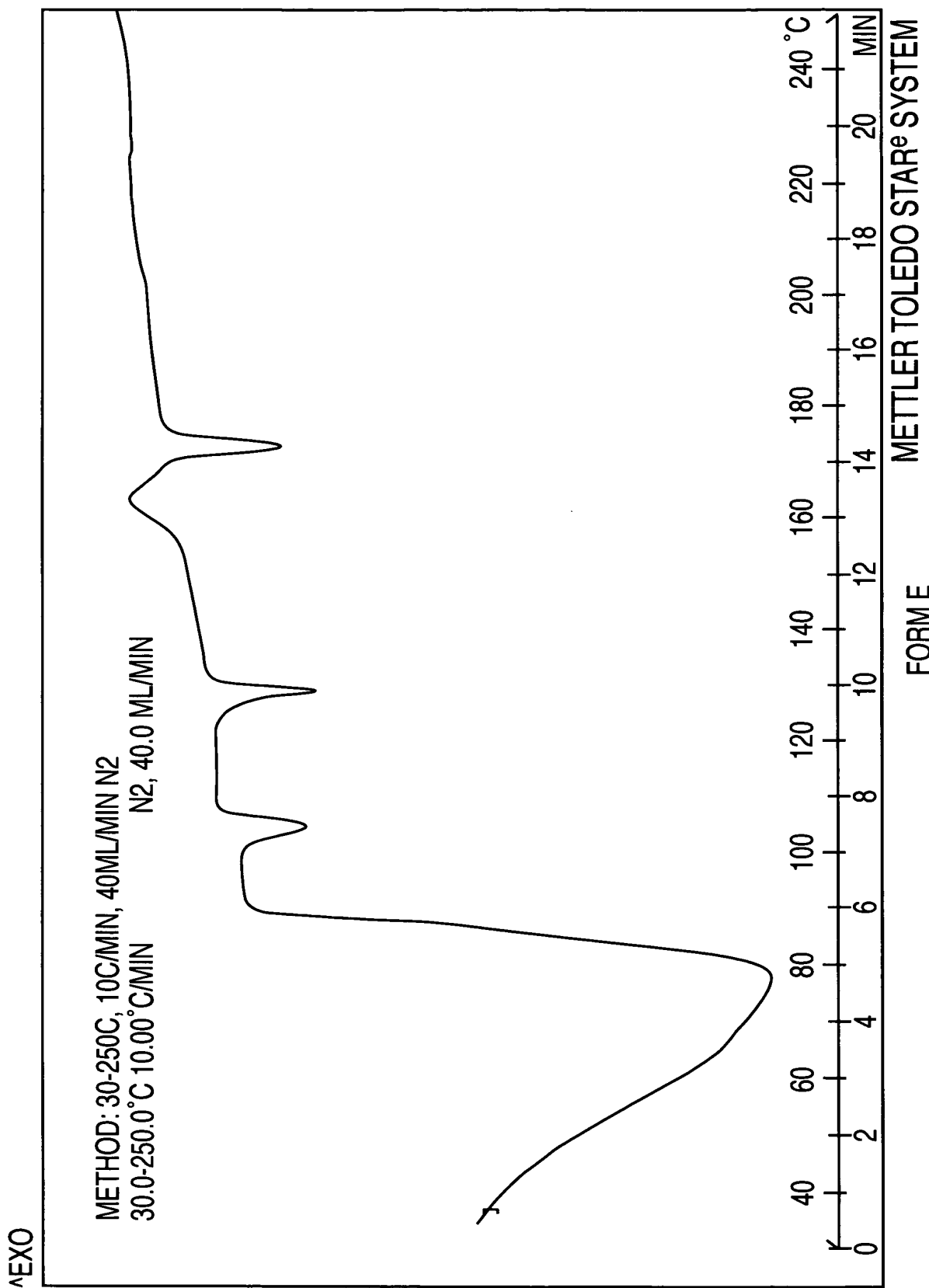
FIG. 35



FORM A
FIG. 36



FORM D
FIG. 37

FORM E
FIG. 38

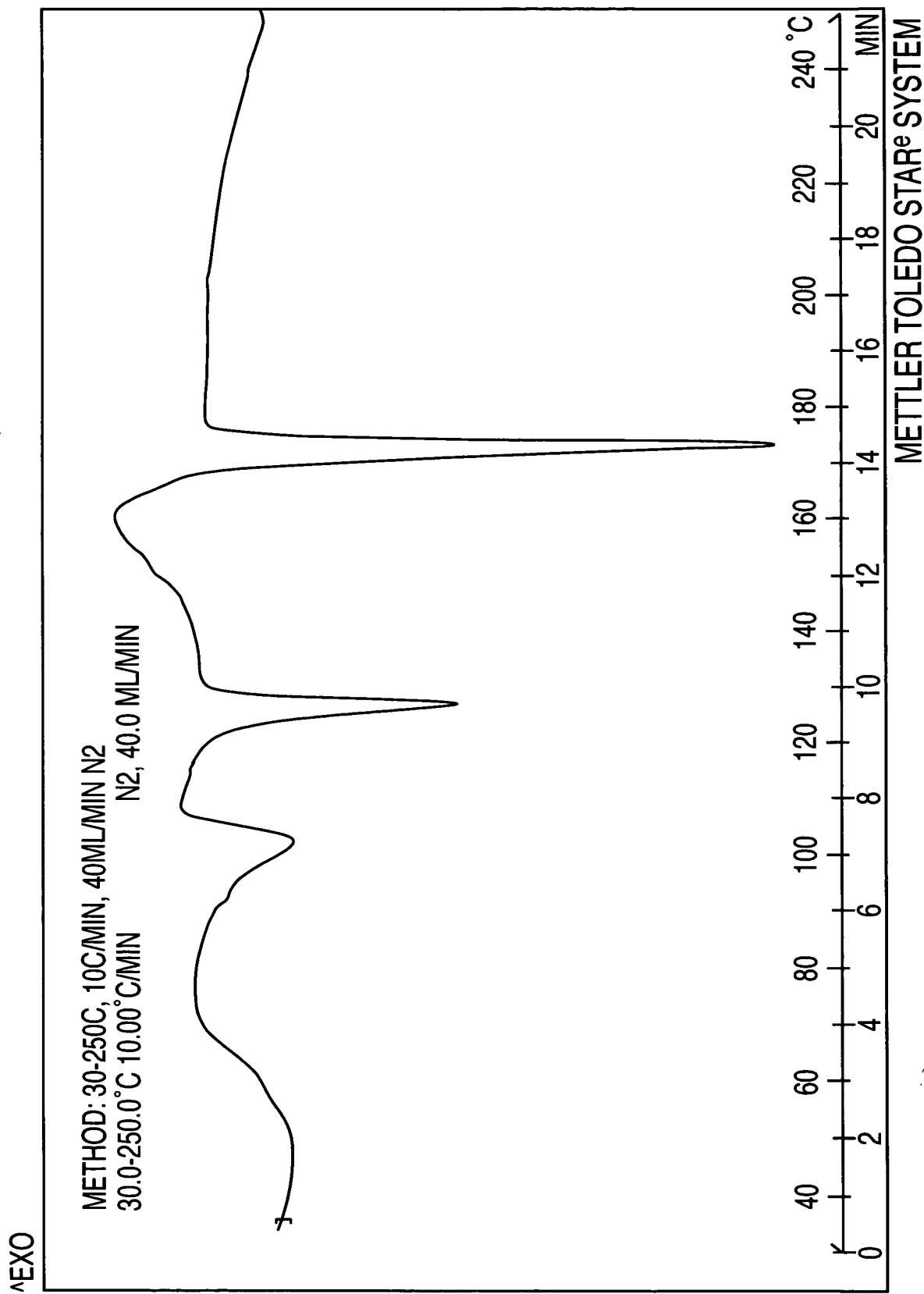


FIG. 39

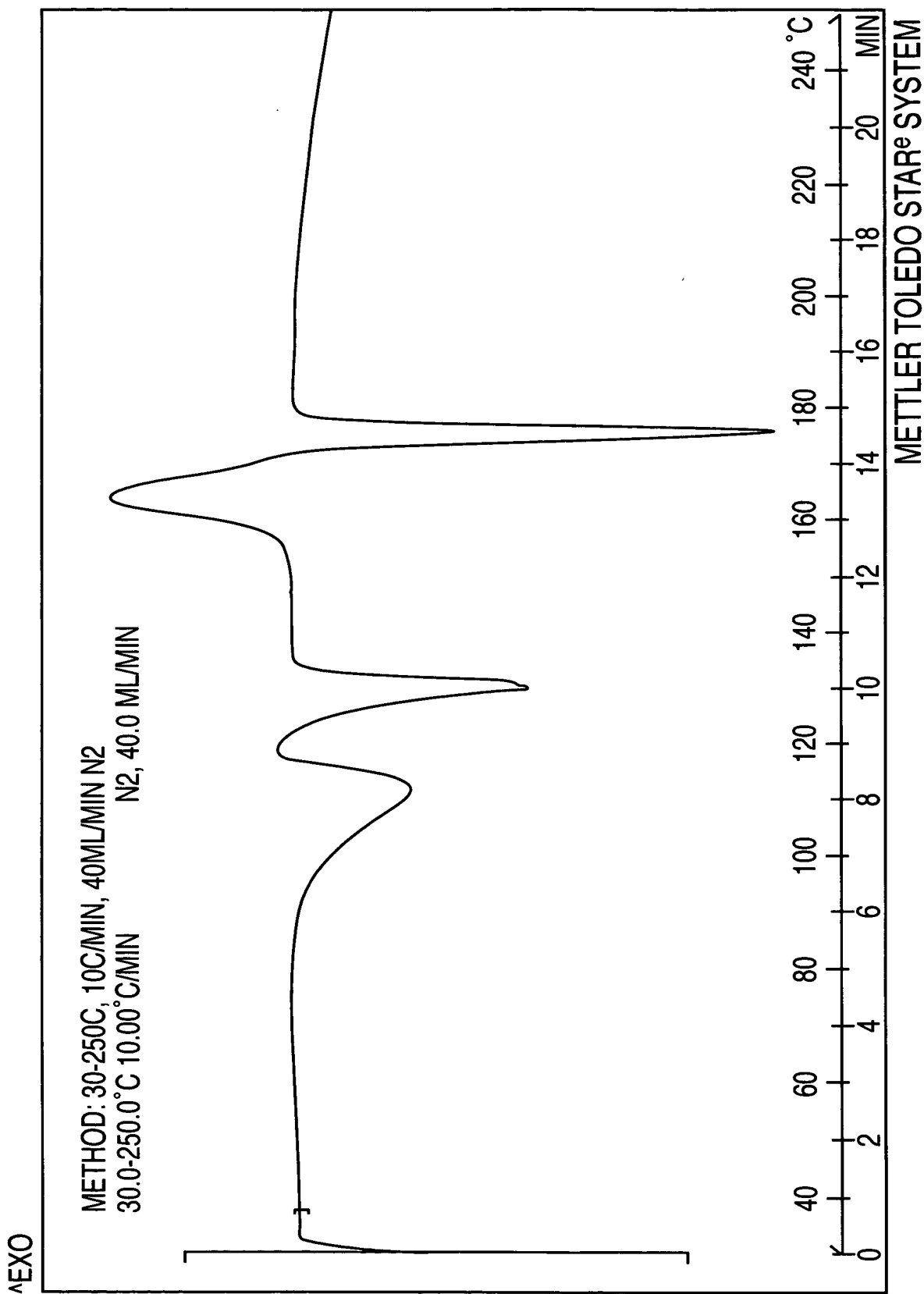
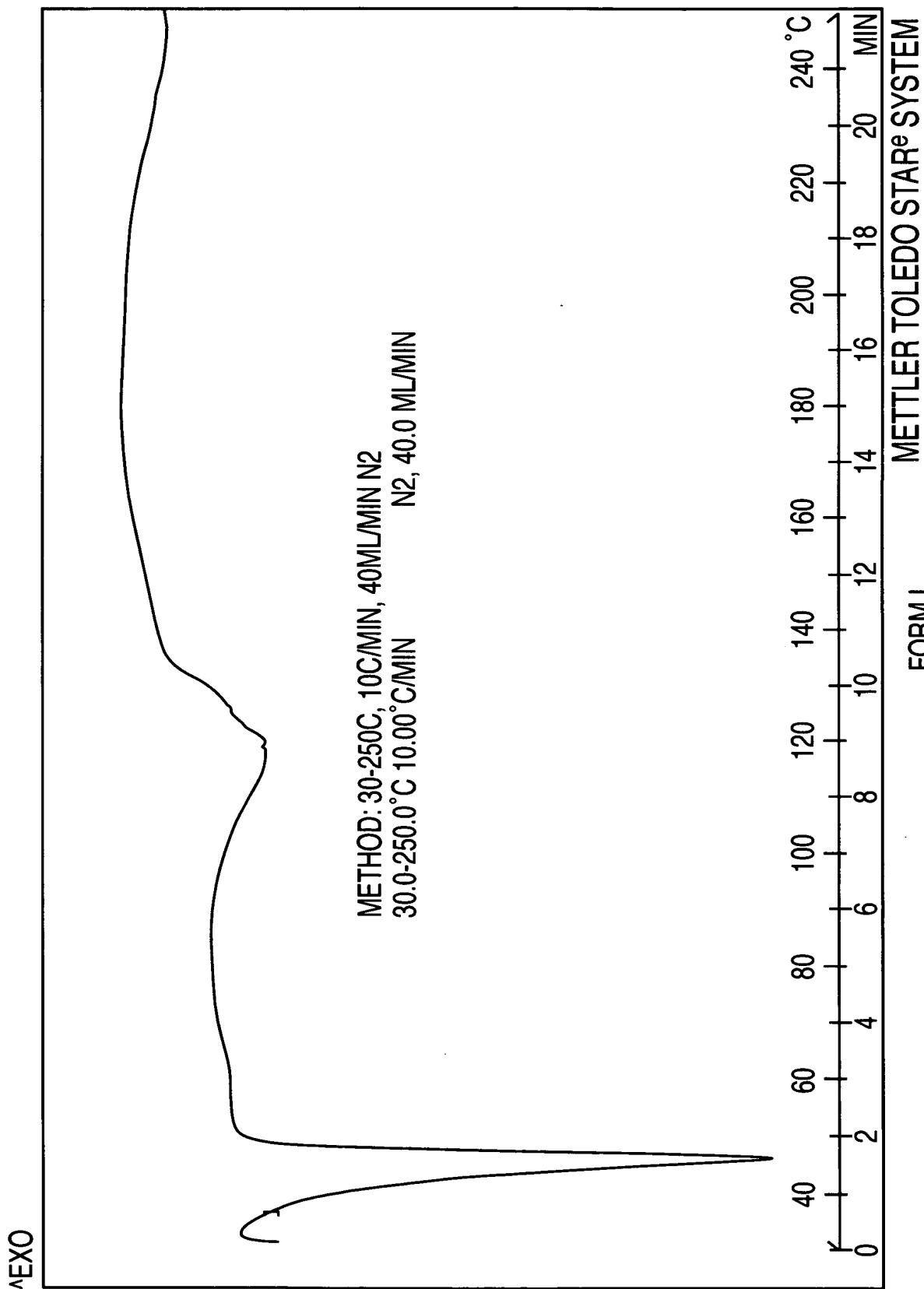


FIG. 40



FORM I

FIG. 41

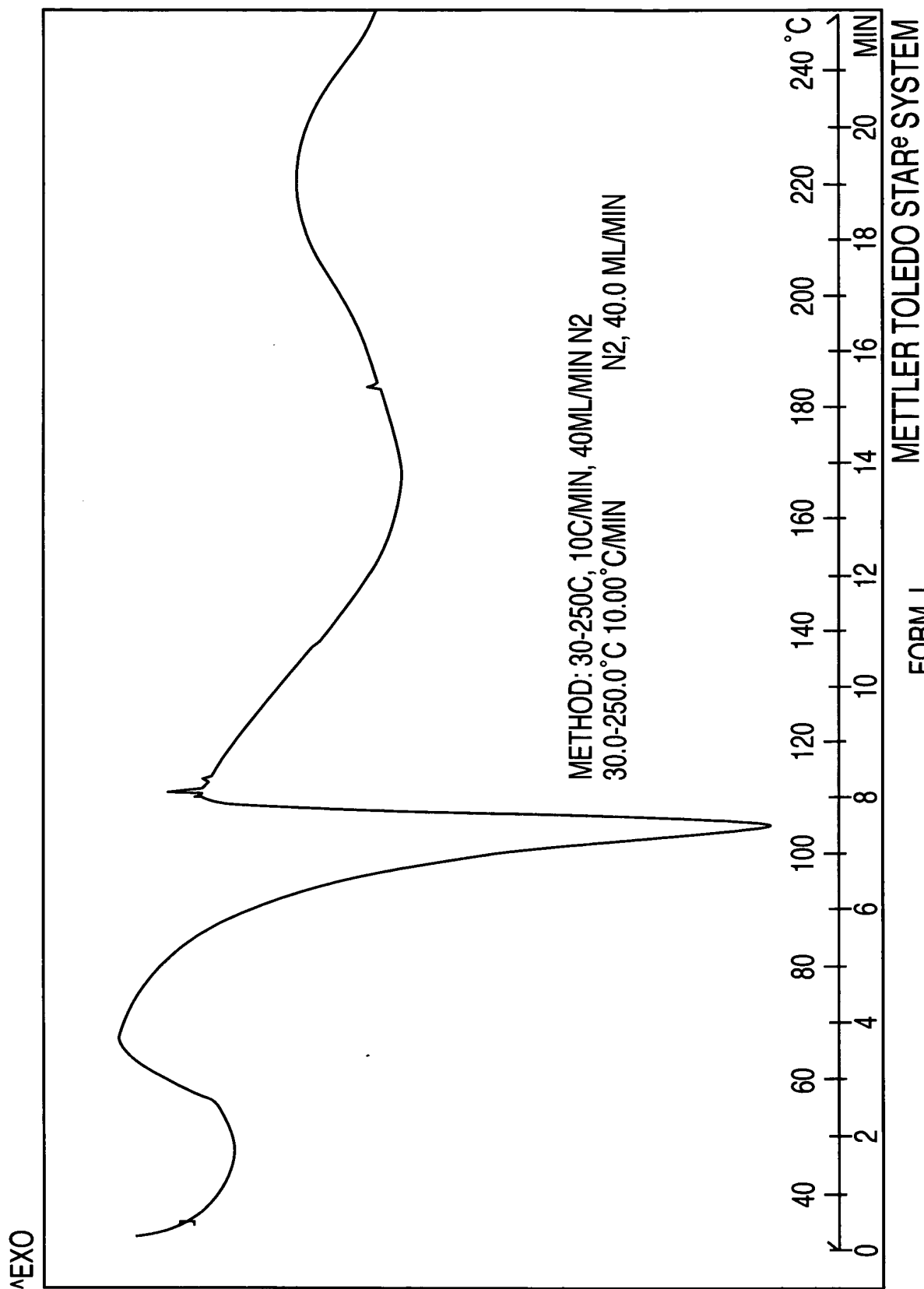
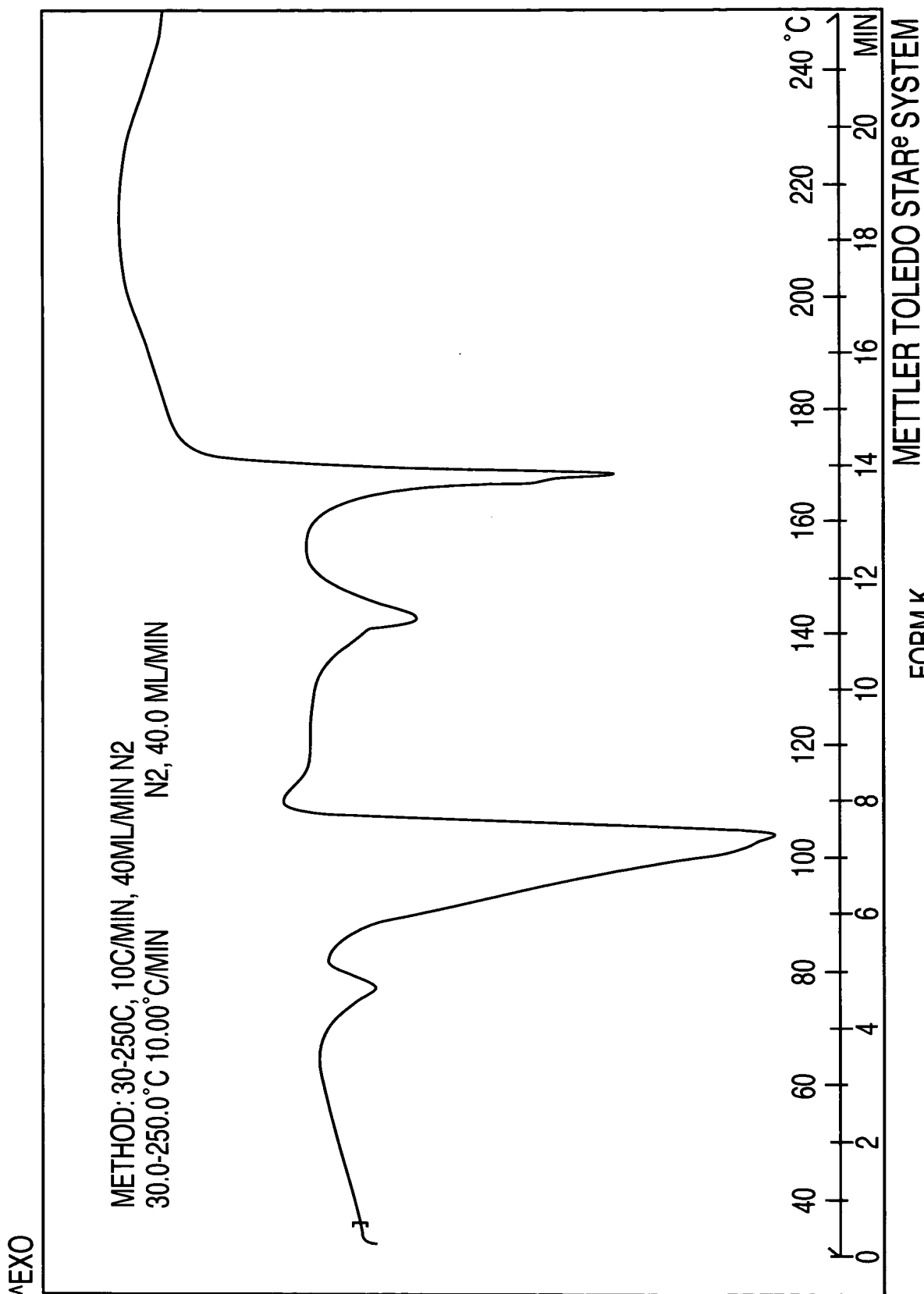
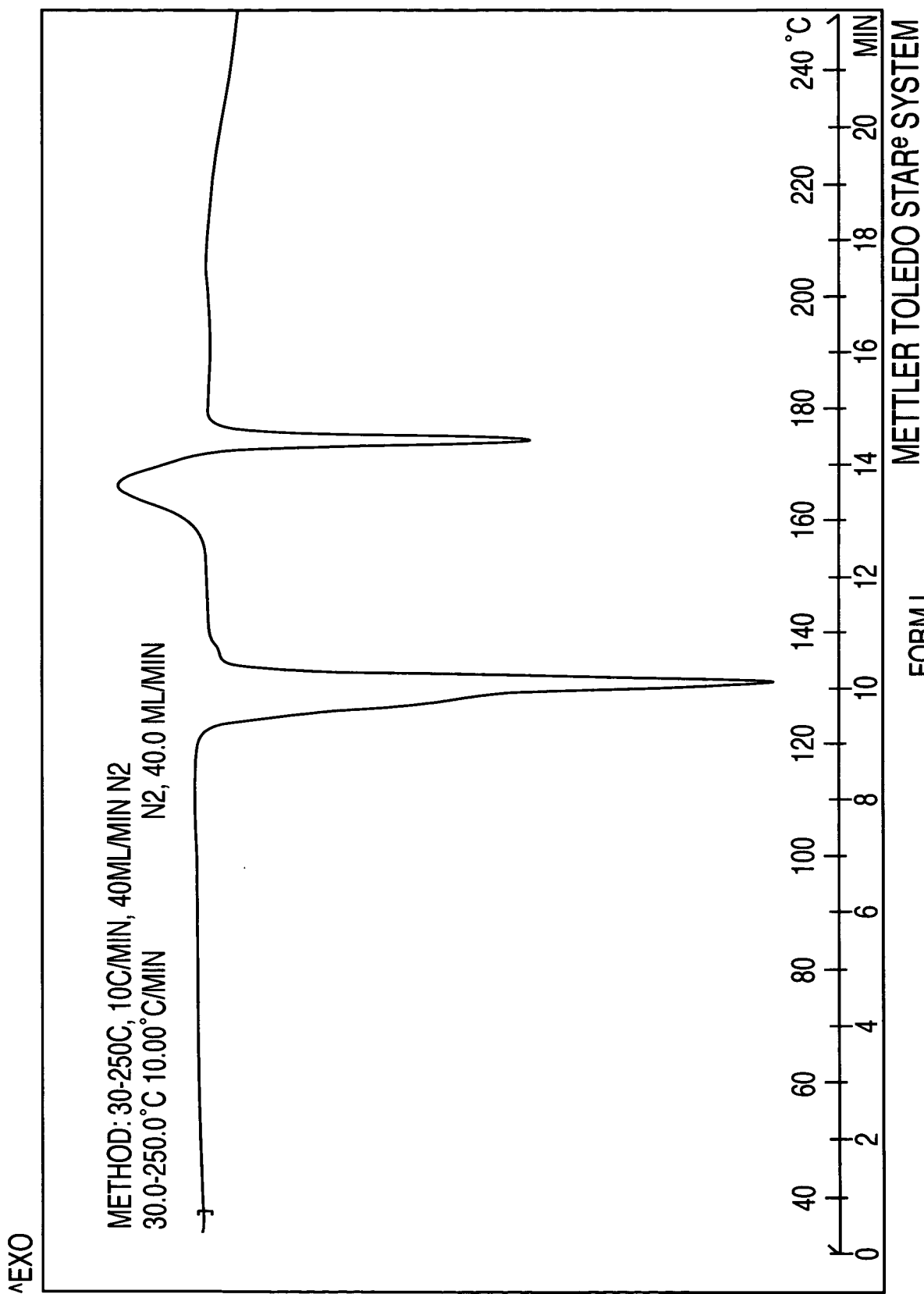


FIG. 42



FORM K
FIG. 43



FORM L
FIG. 44

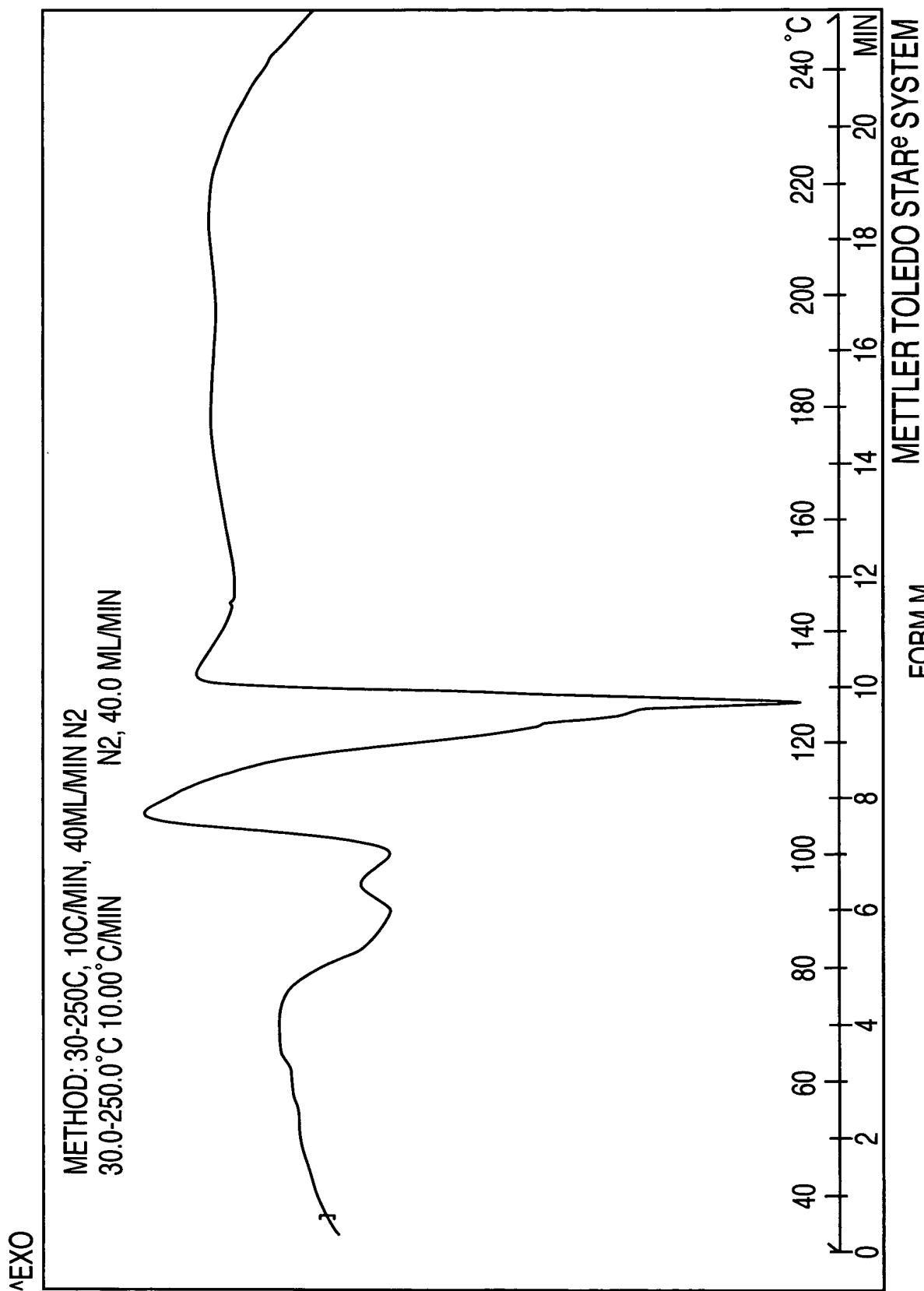
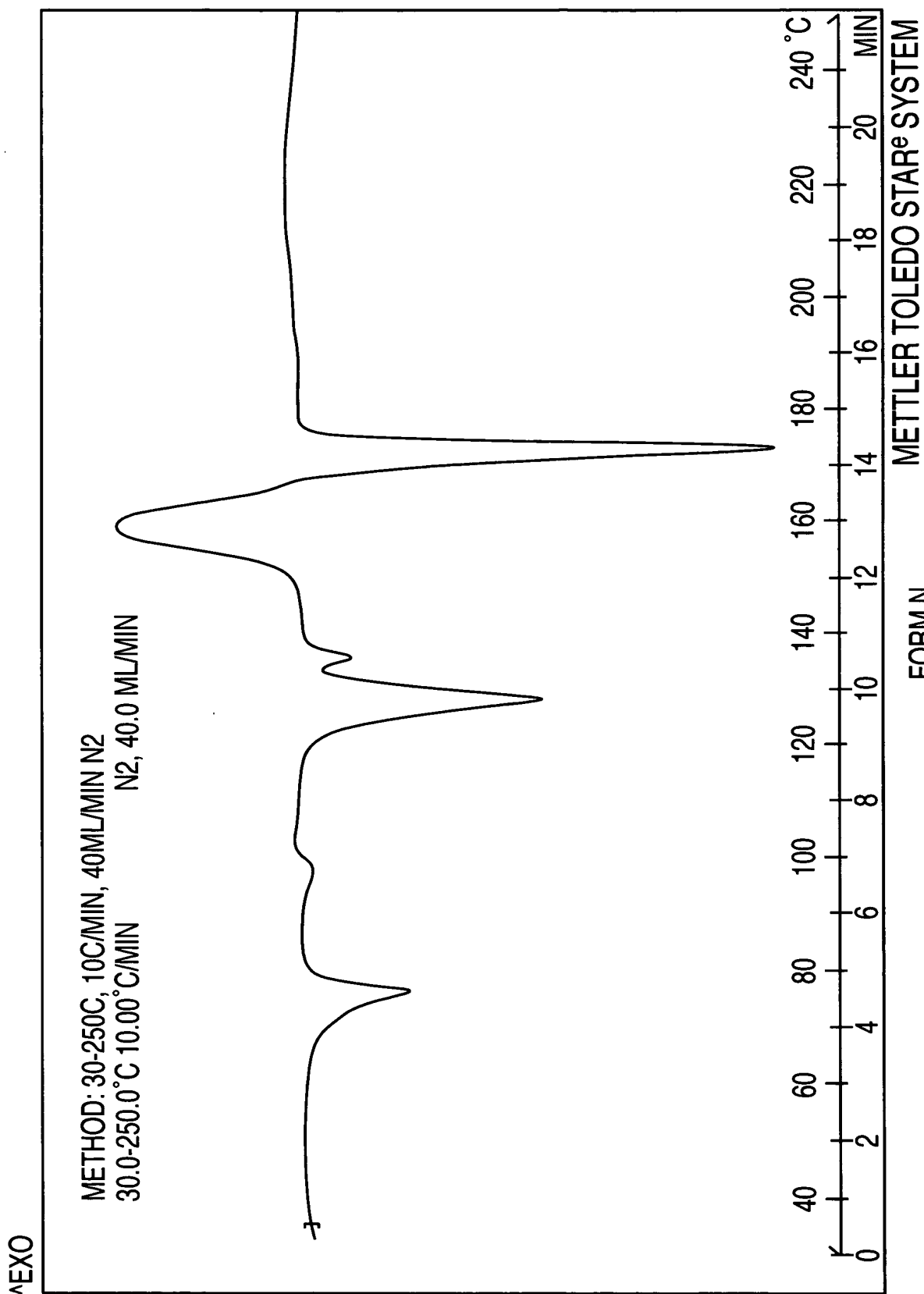
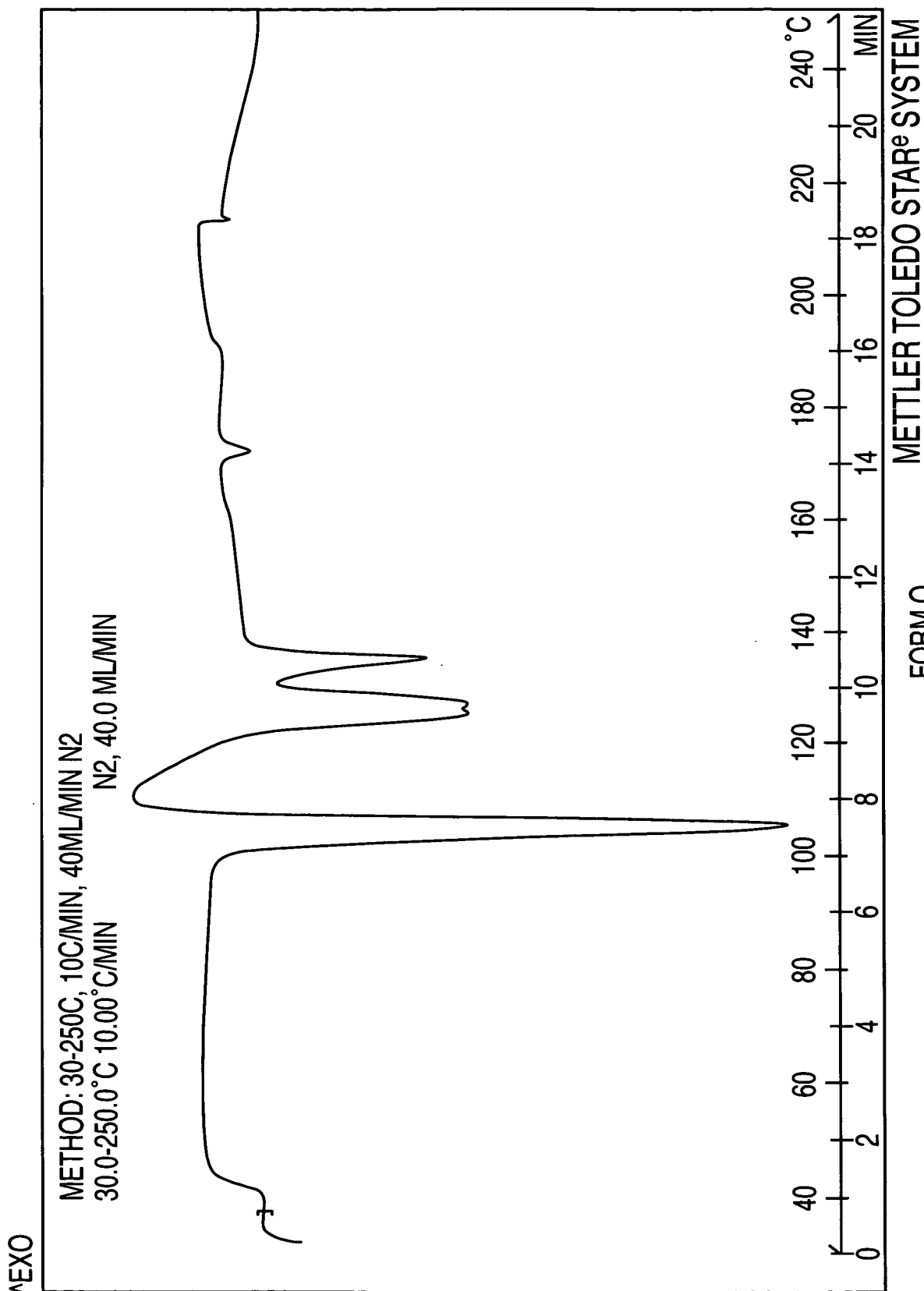


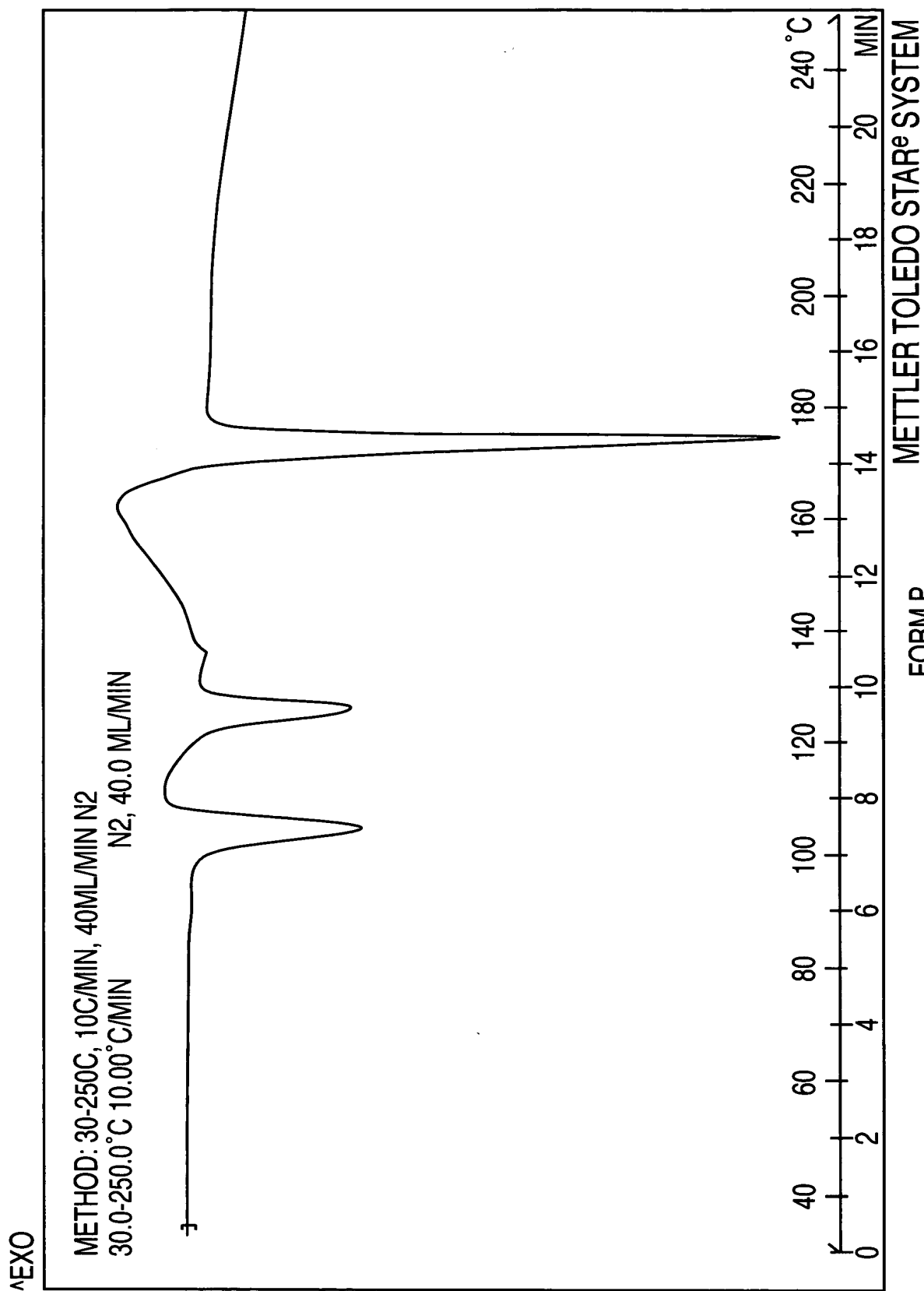
FIG. 45



FORM N
FIG. 46

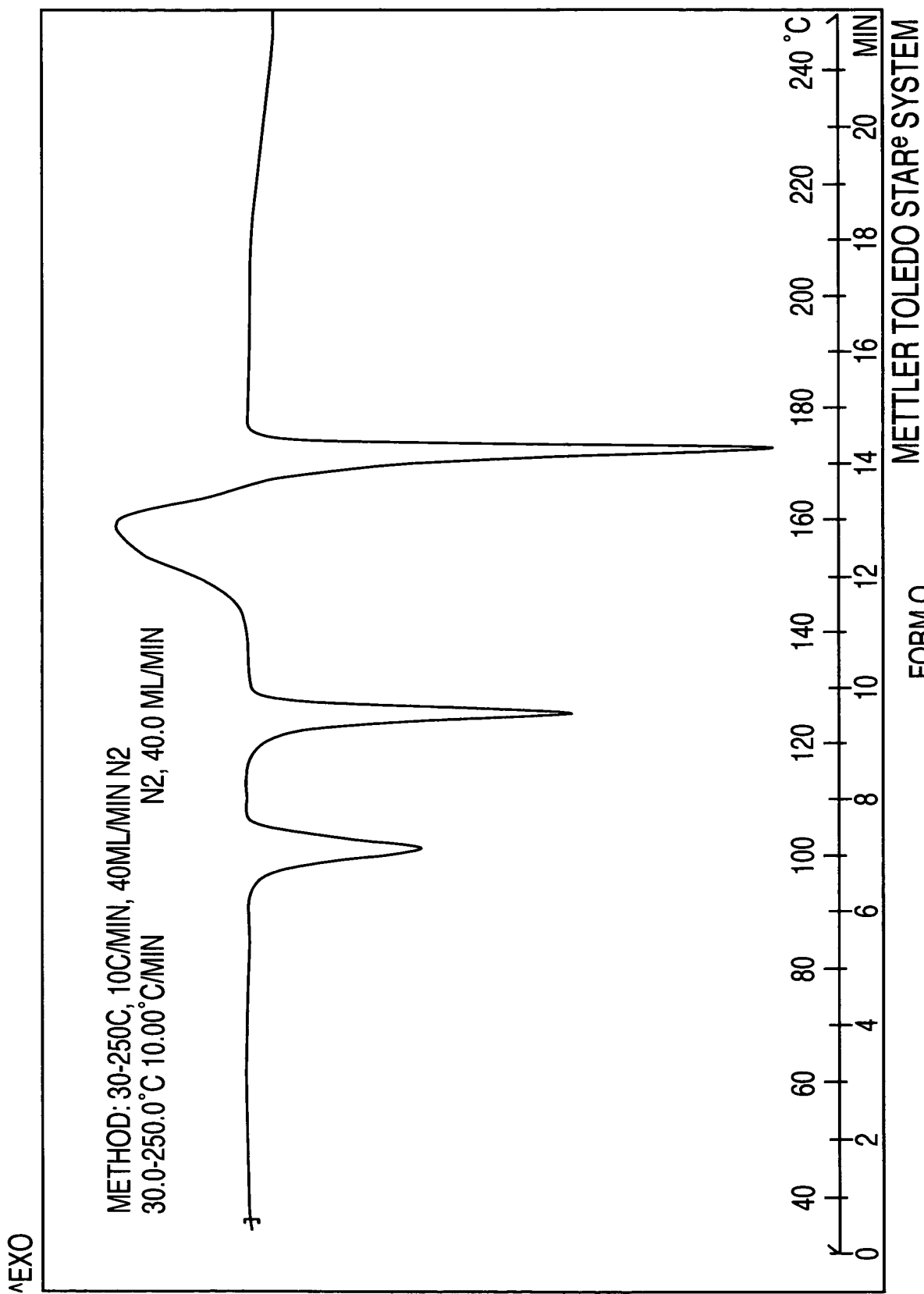


FORM O
FIG. 47

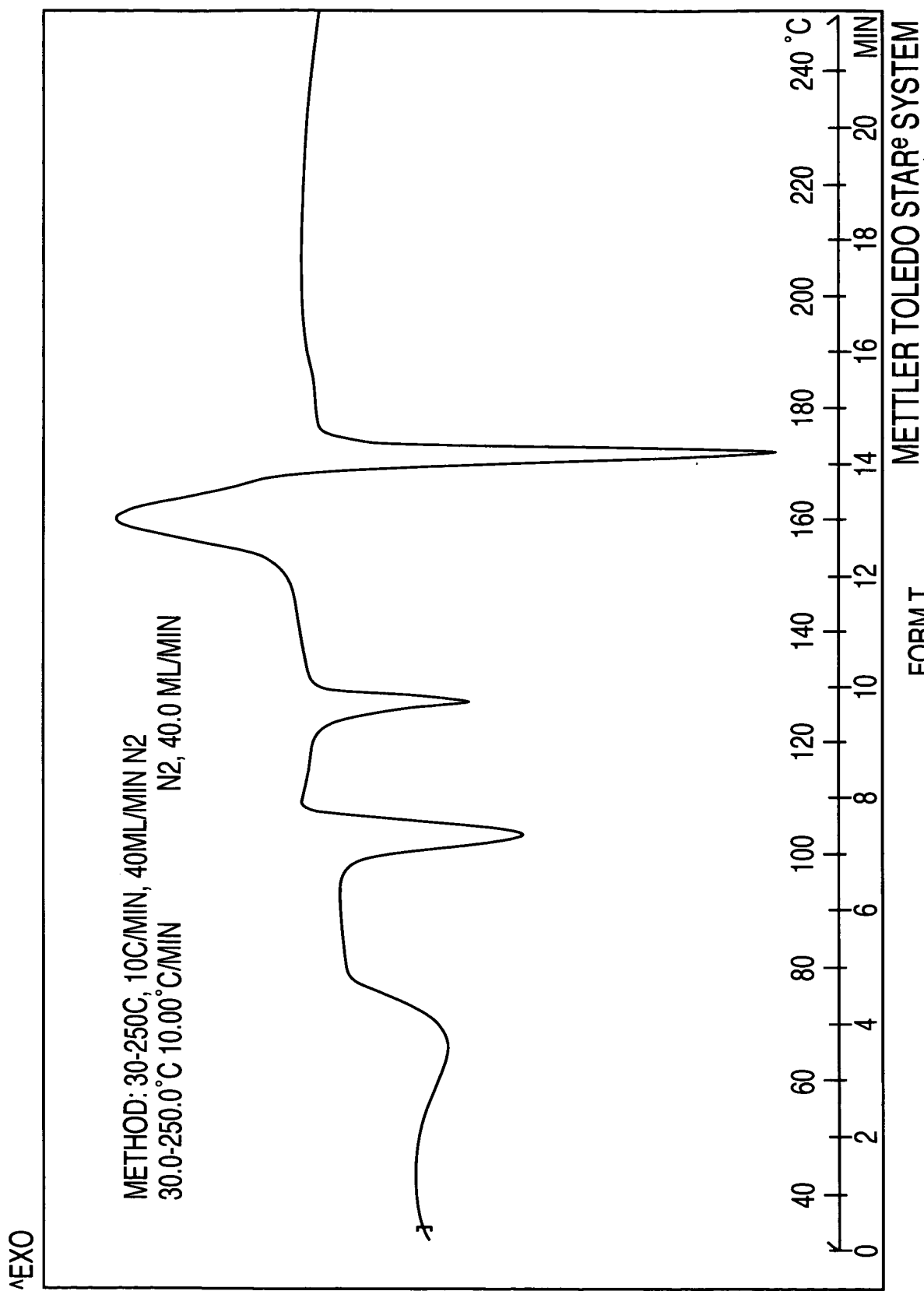


FORM P

FIG. 48

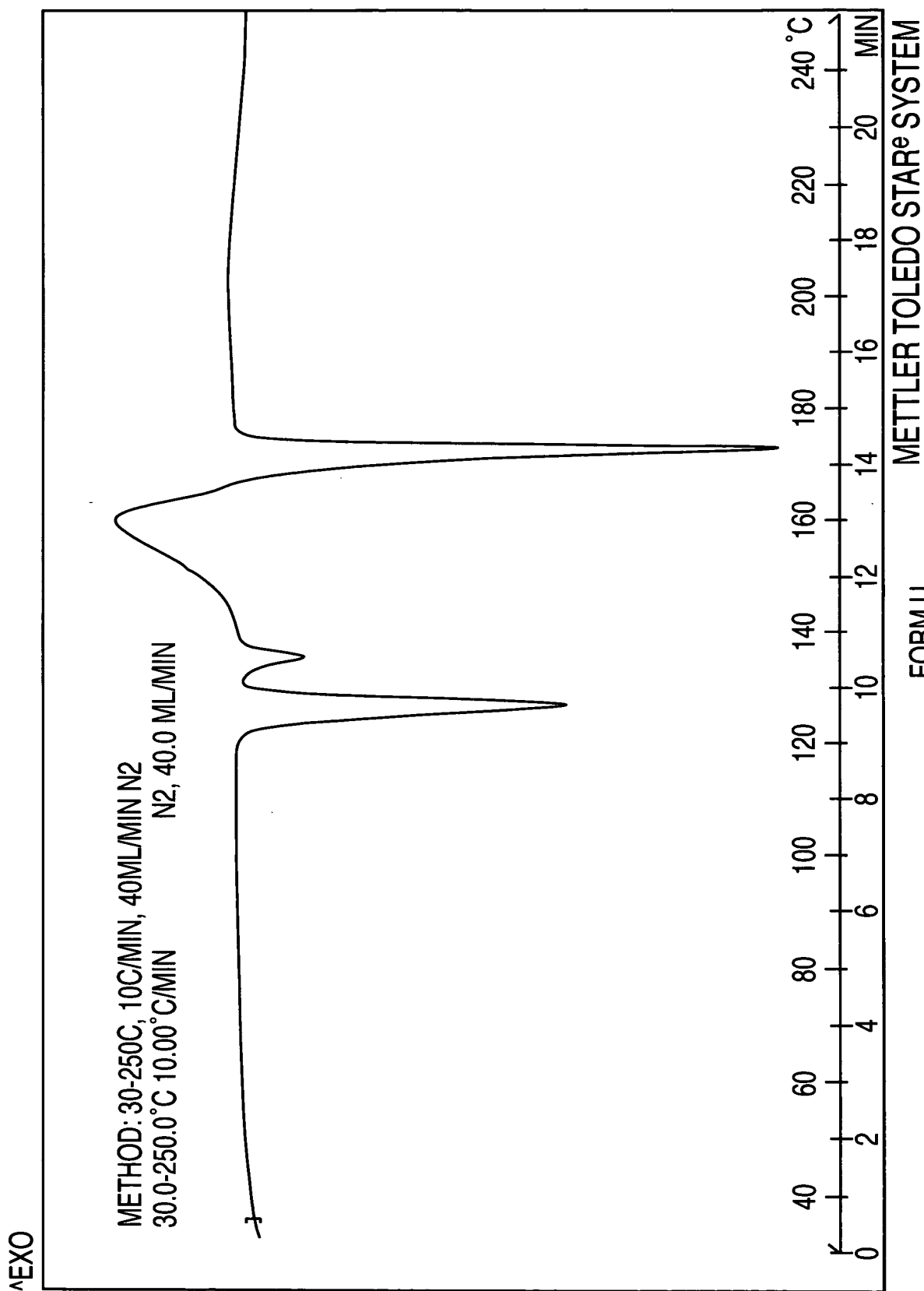


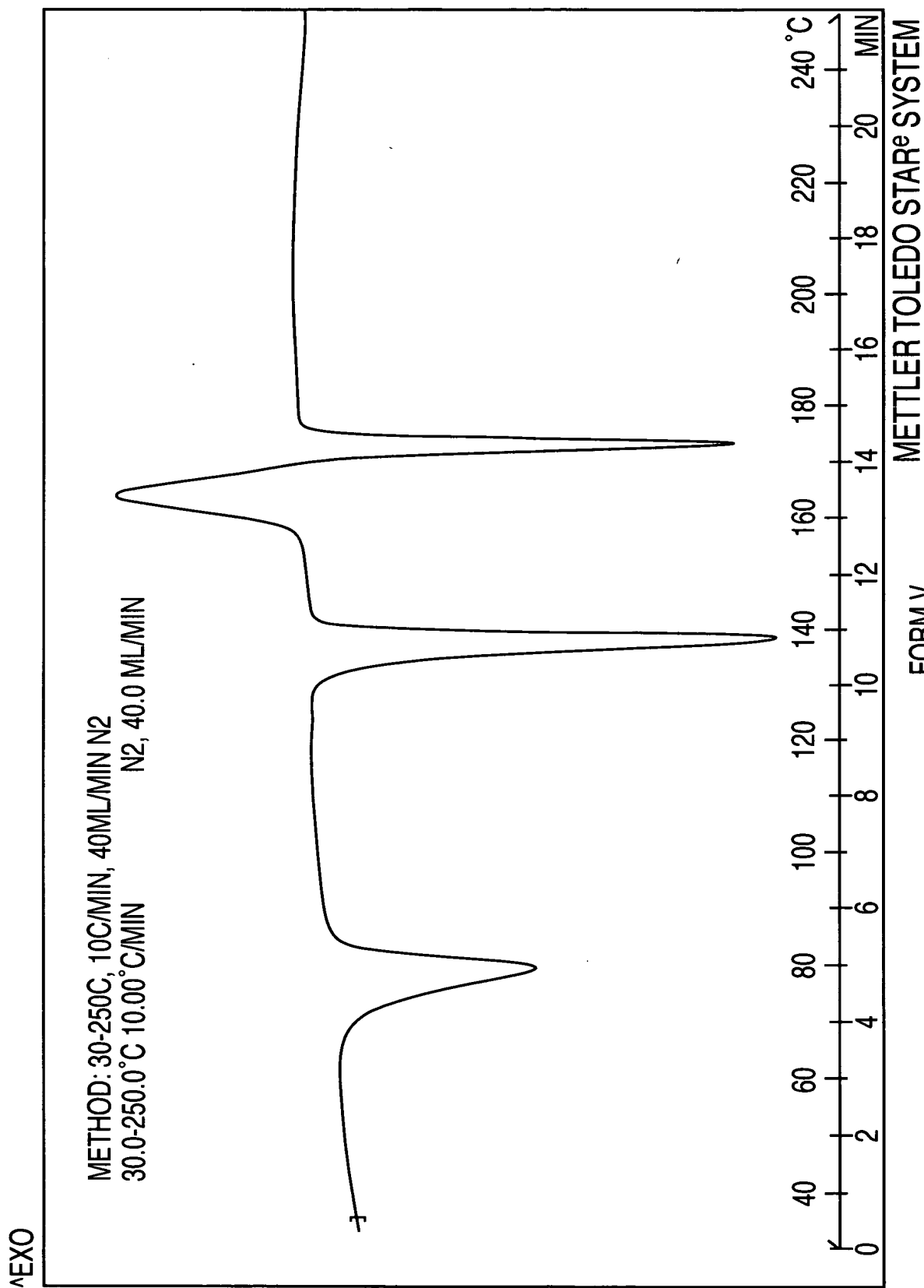
FORM Q
FIG. 49



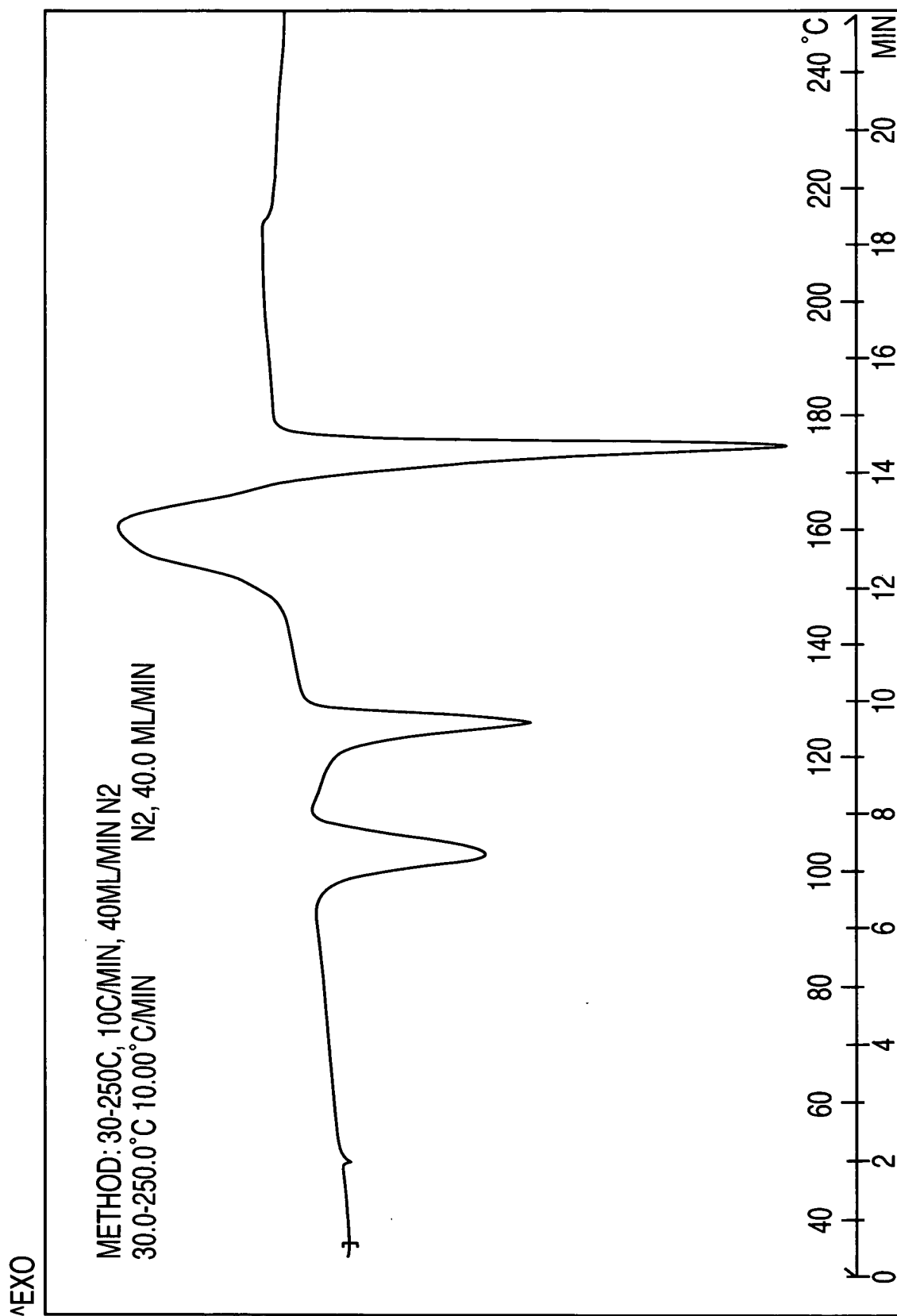
FORM T

FIG. 50

FORM U
FIG. 51



FORM V
FIG. 52



METTLER TOLEDO STAR® SYSTEM

FIG. 53

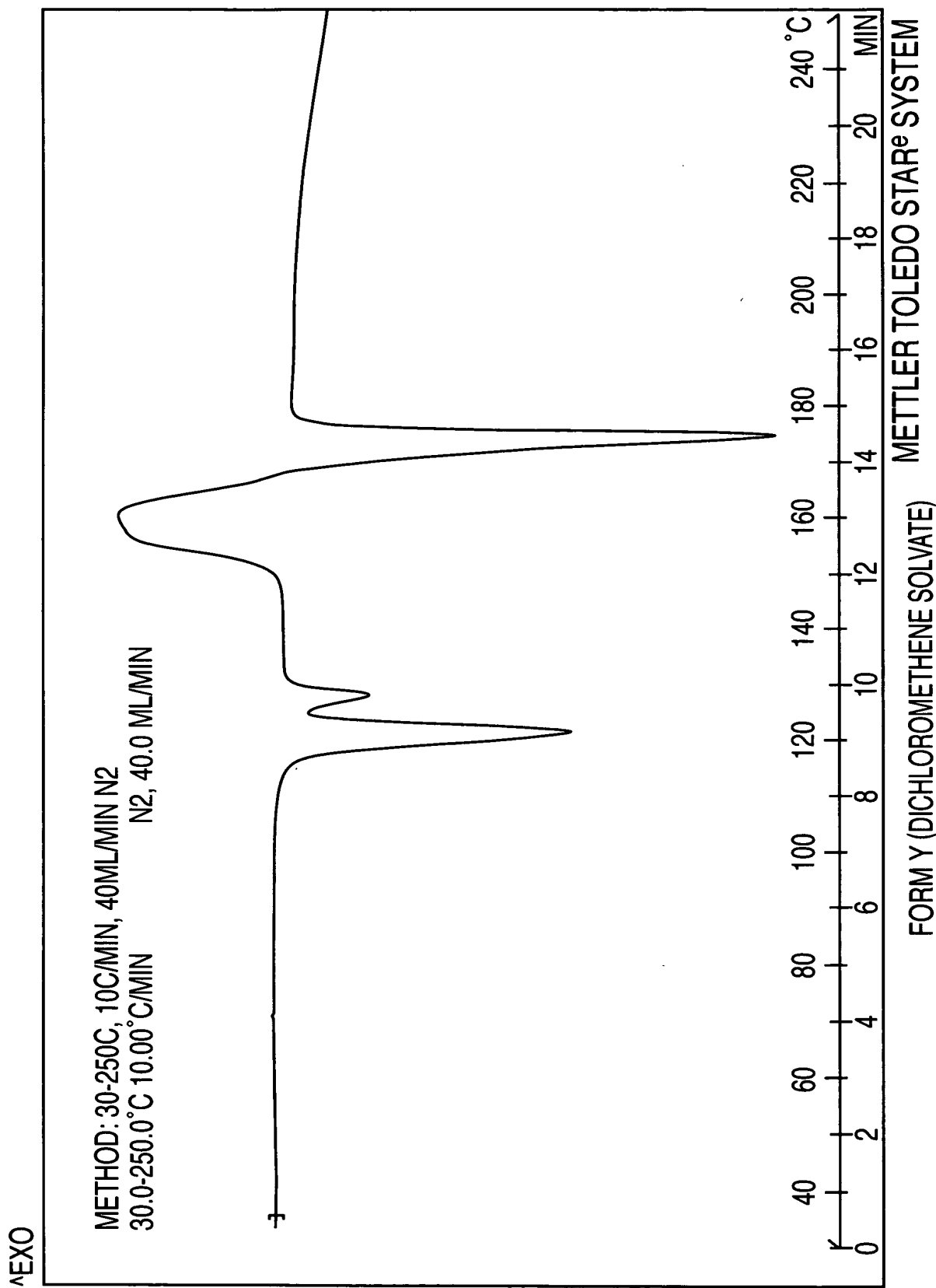
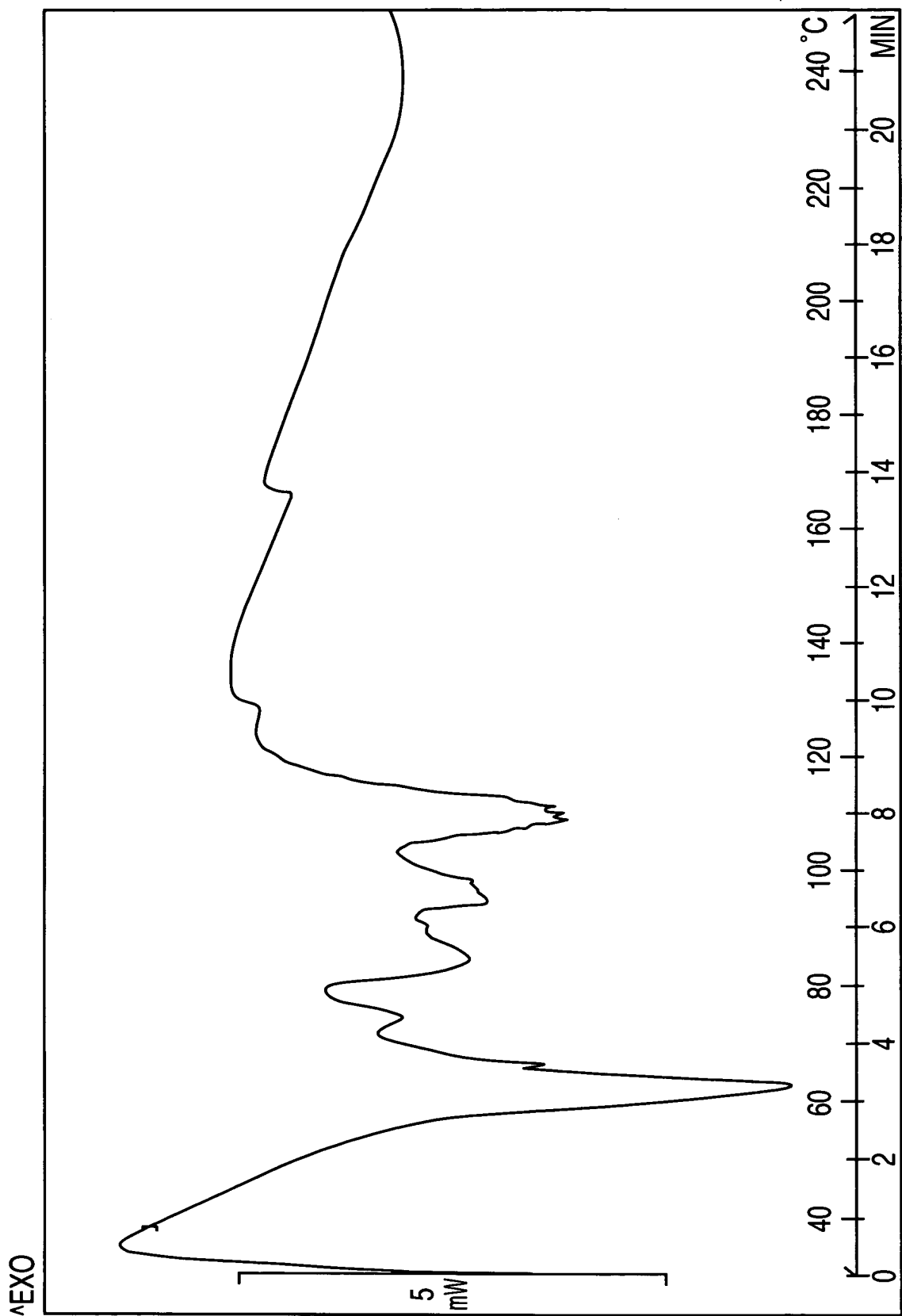
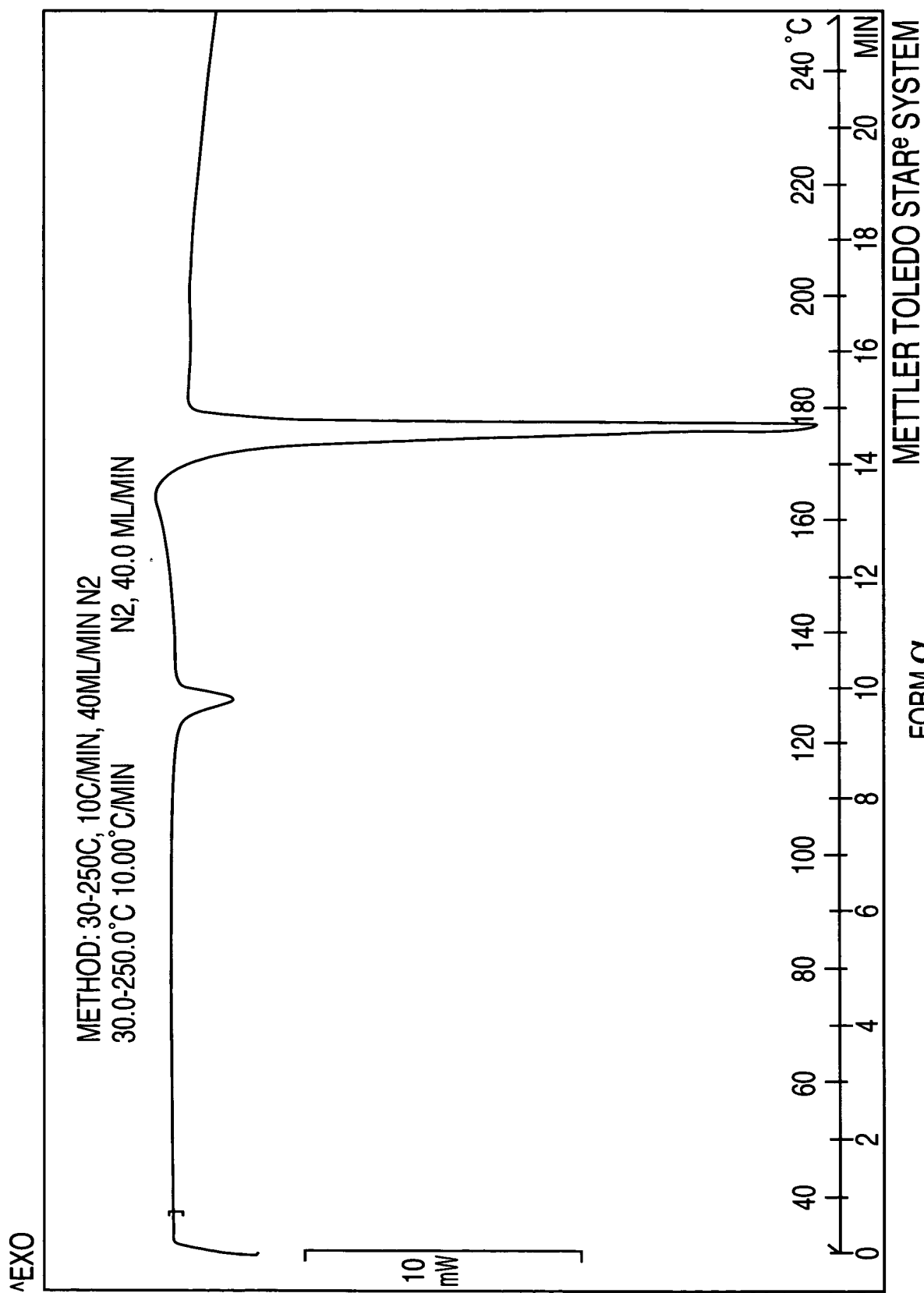


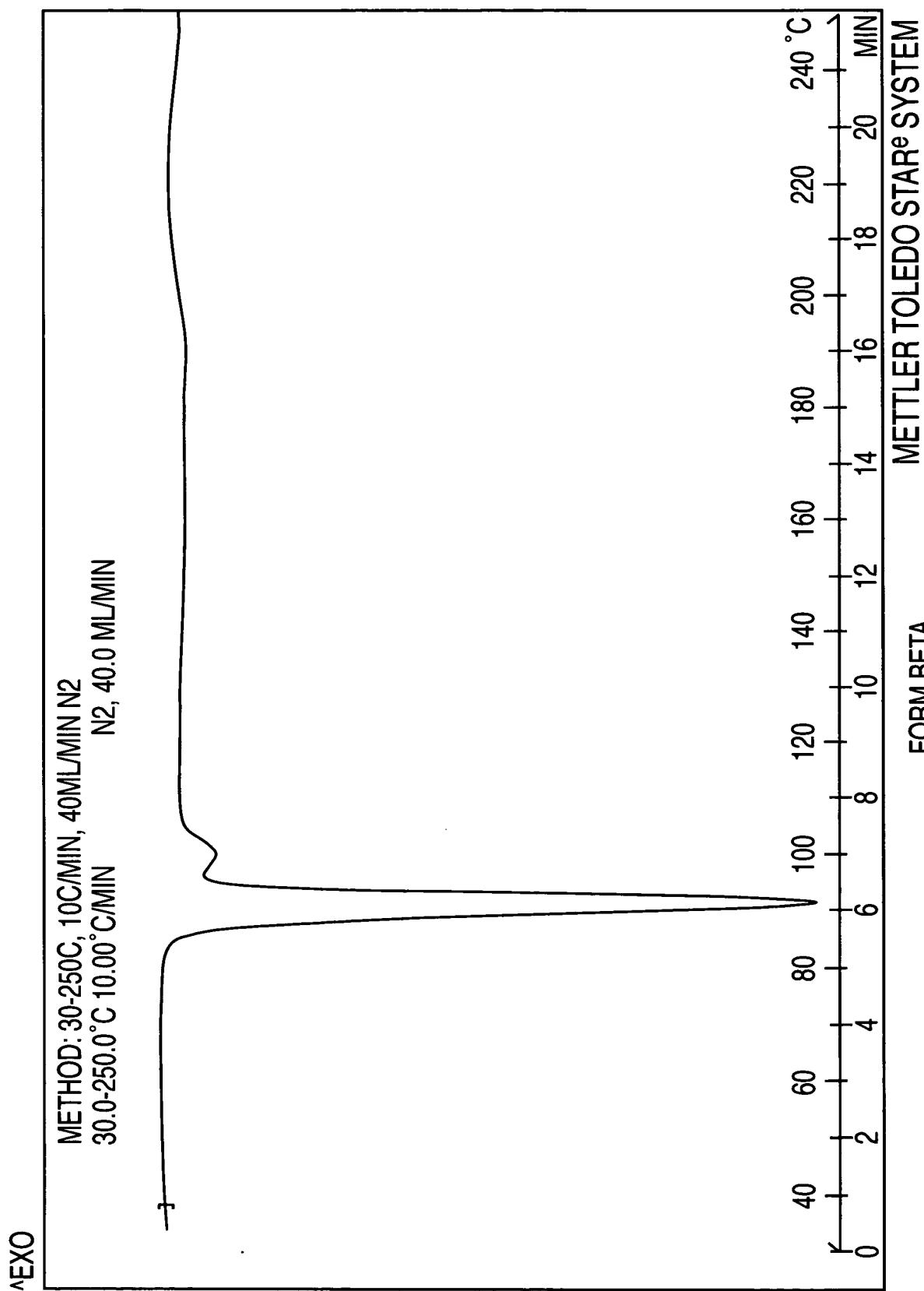
FIG. 54

METTLER TOLEDO STAR^e SYSTEM

FORM Y NATEGLINIDE FORM Z

FIG. 55

FORM α
FIG. 56



FORM BETA

FIG. 57

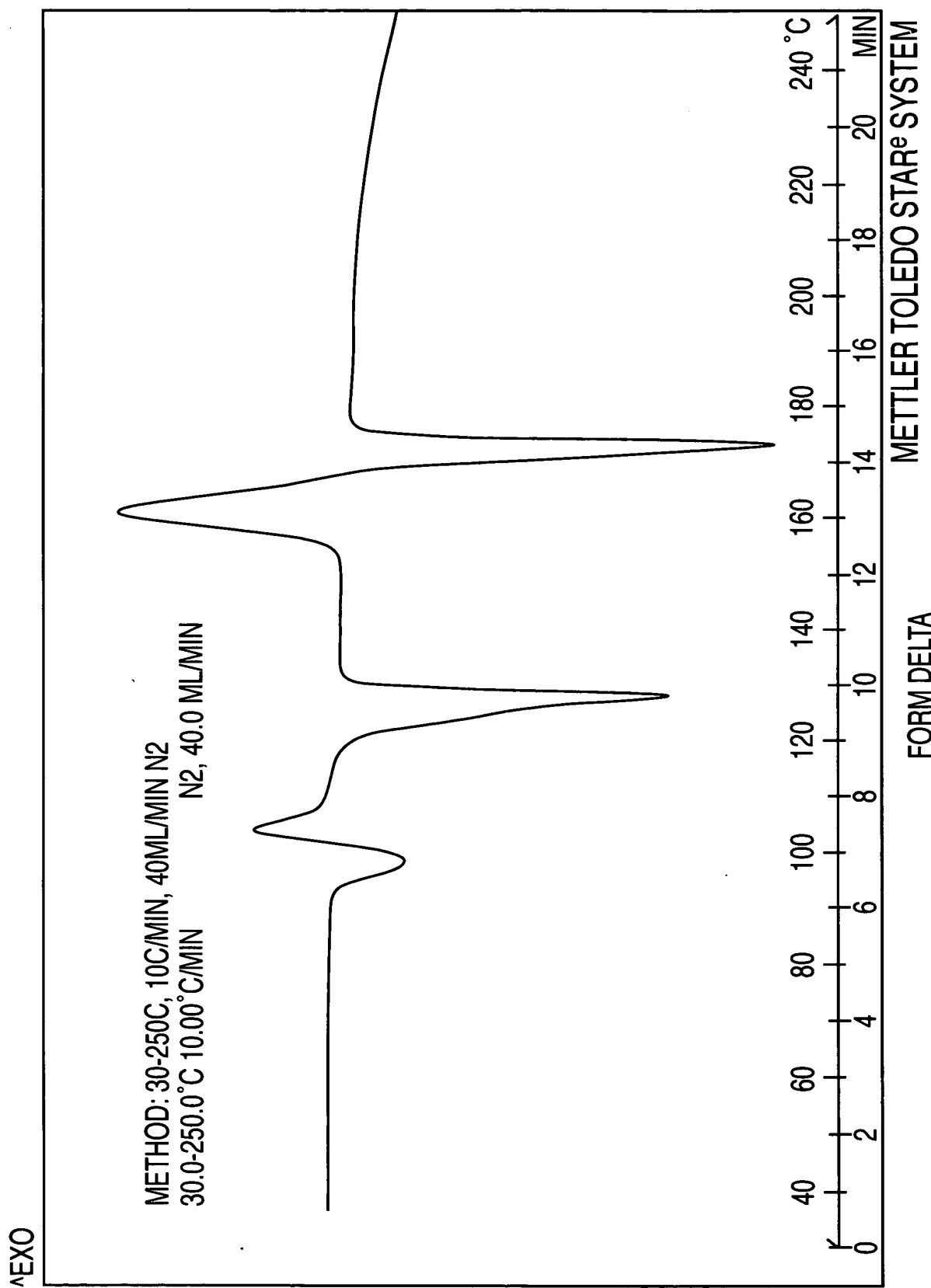


FIG. 58

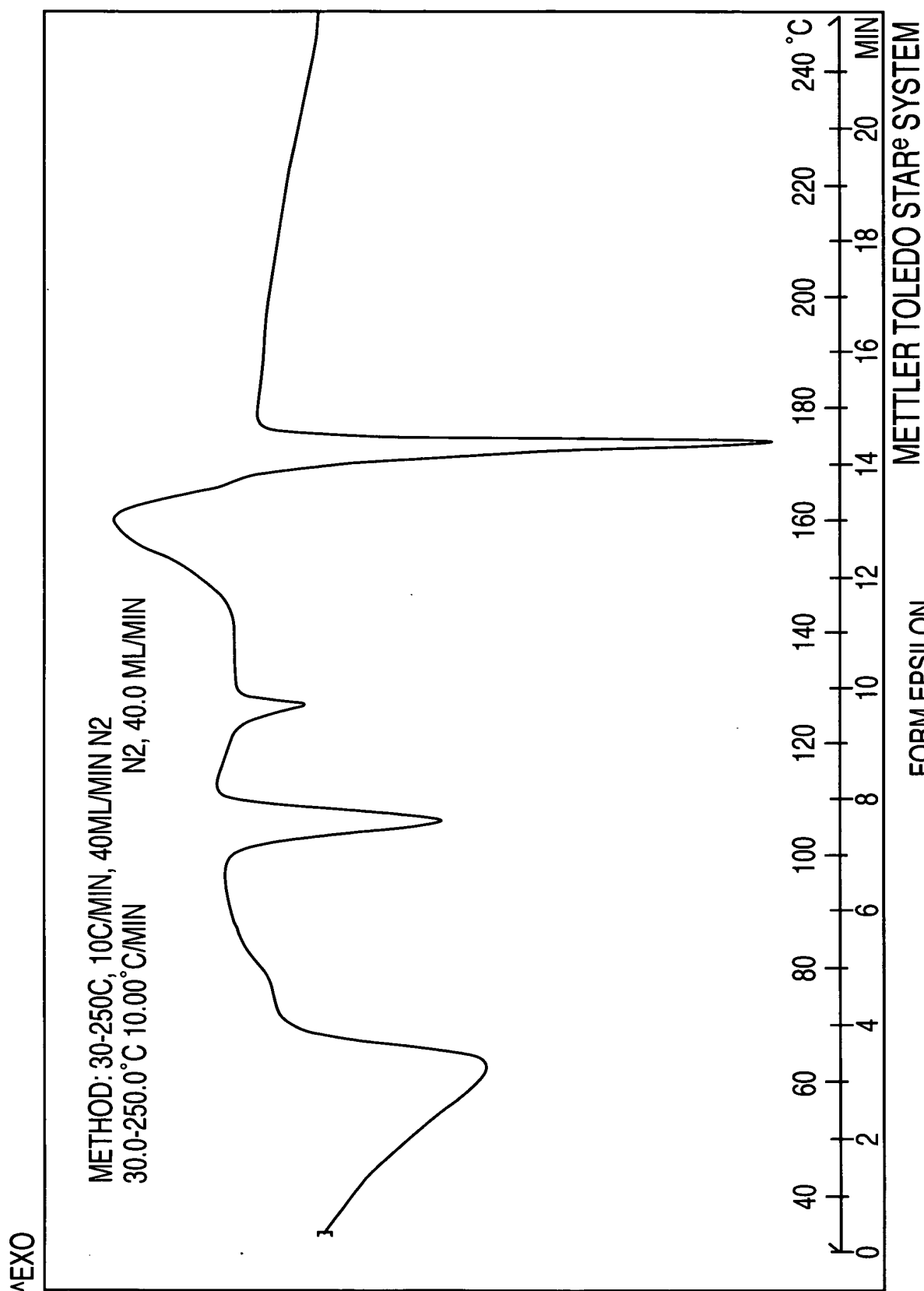


FIG. 59

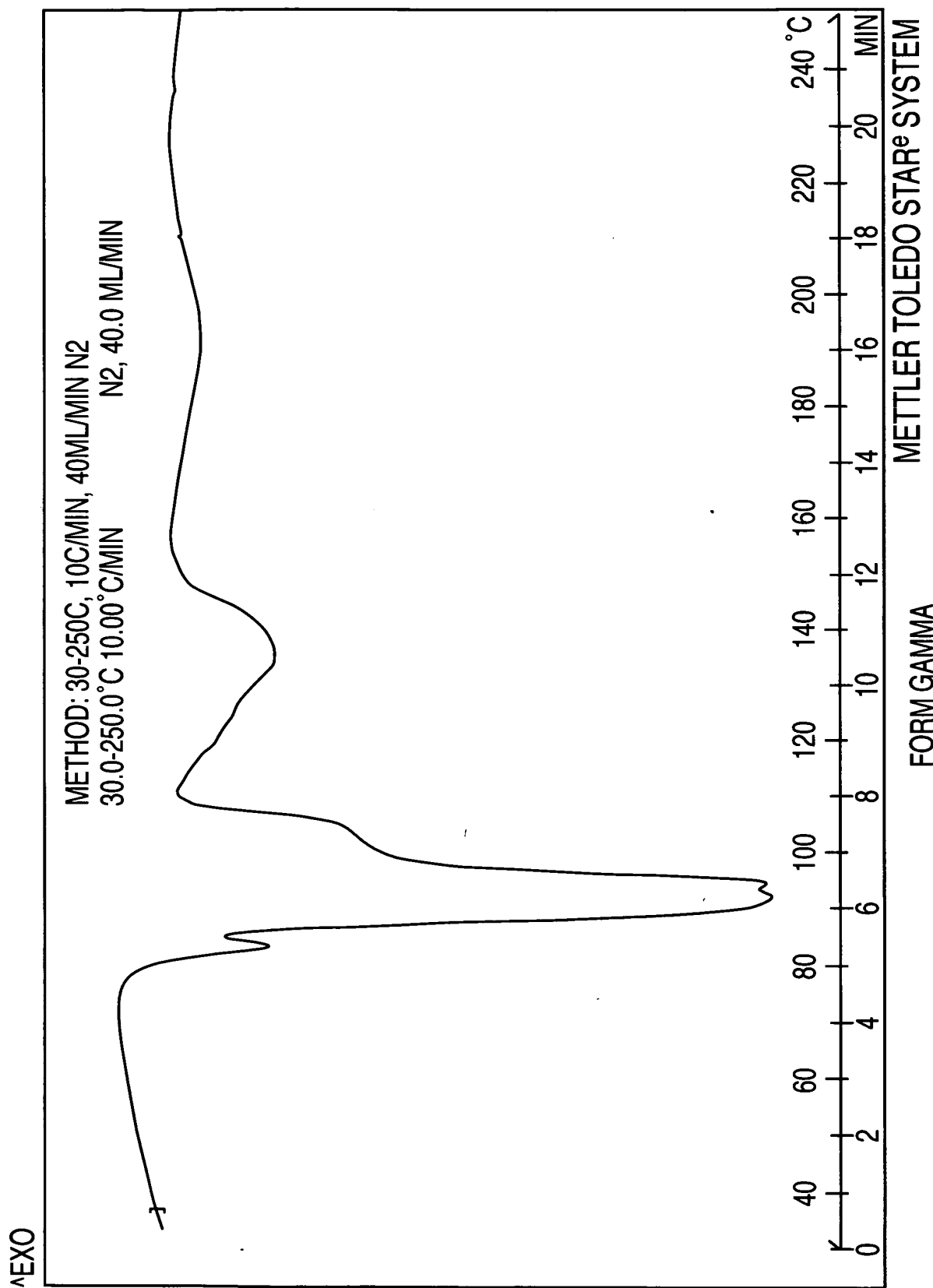


FIG. 60

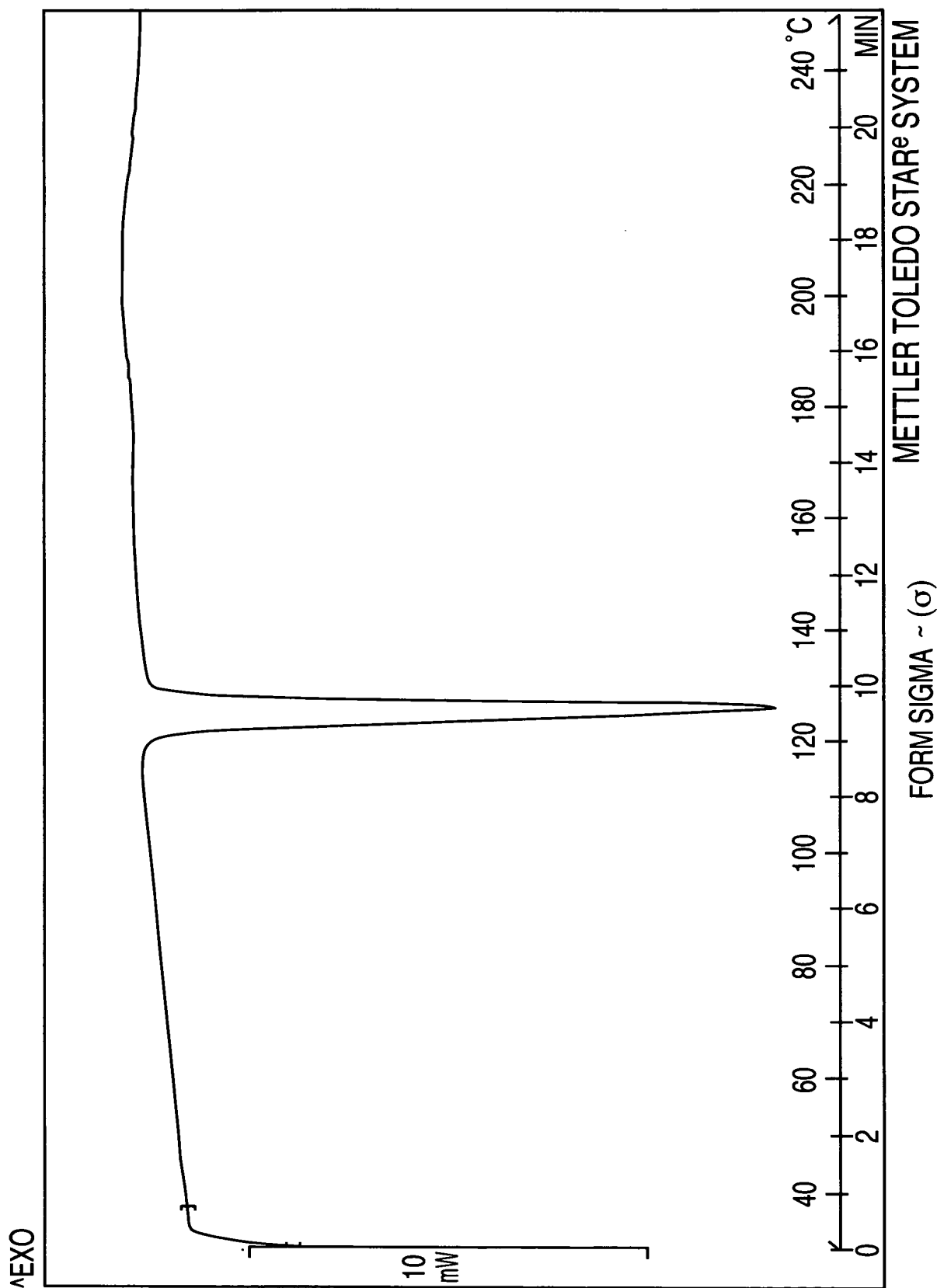


FIG. 61

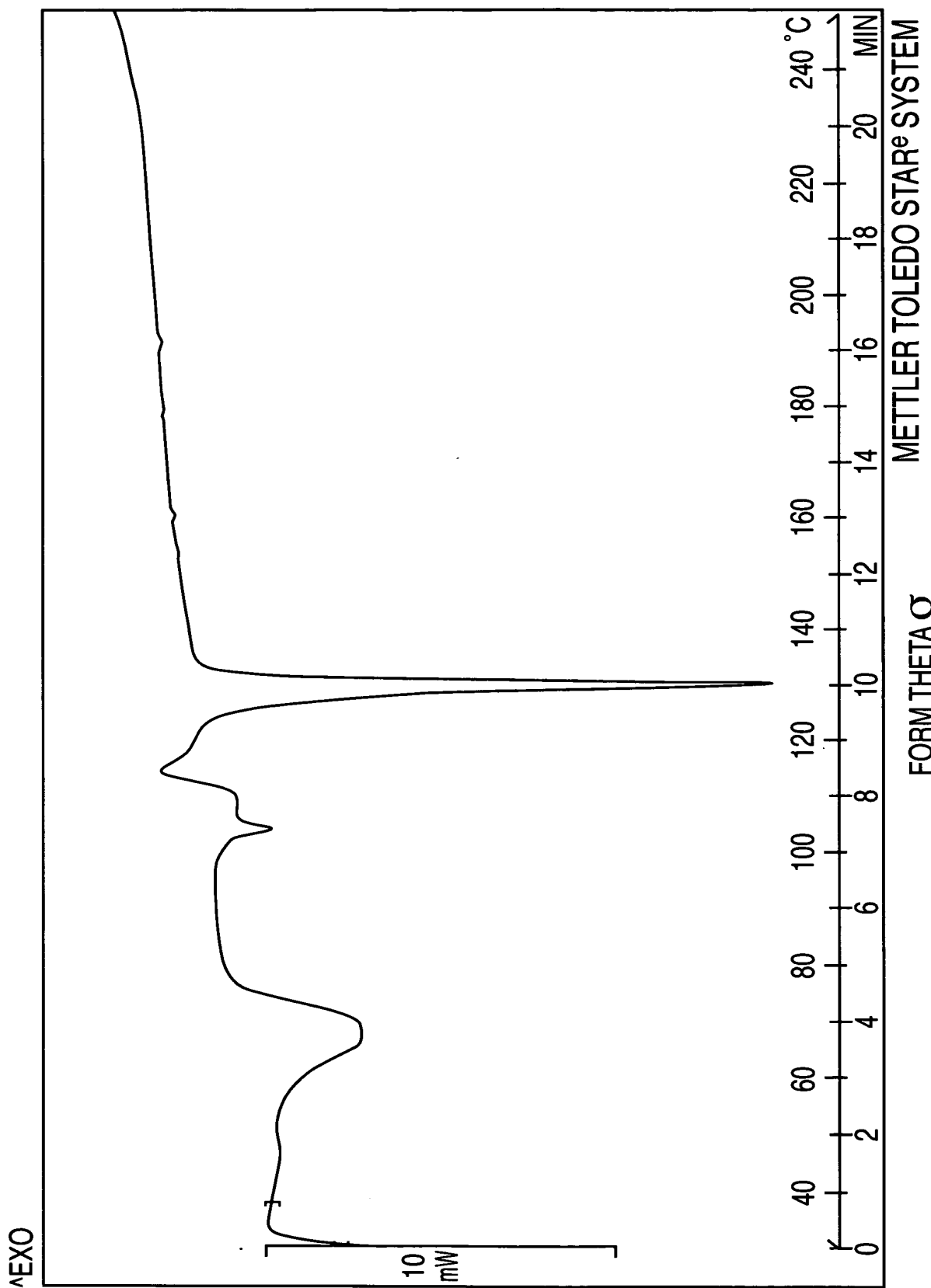


FIG. 62

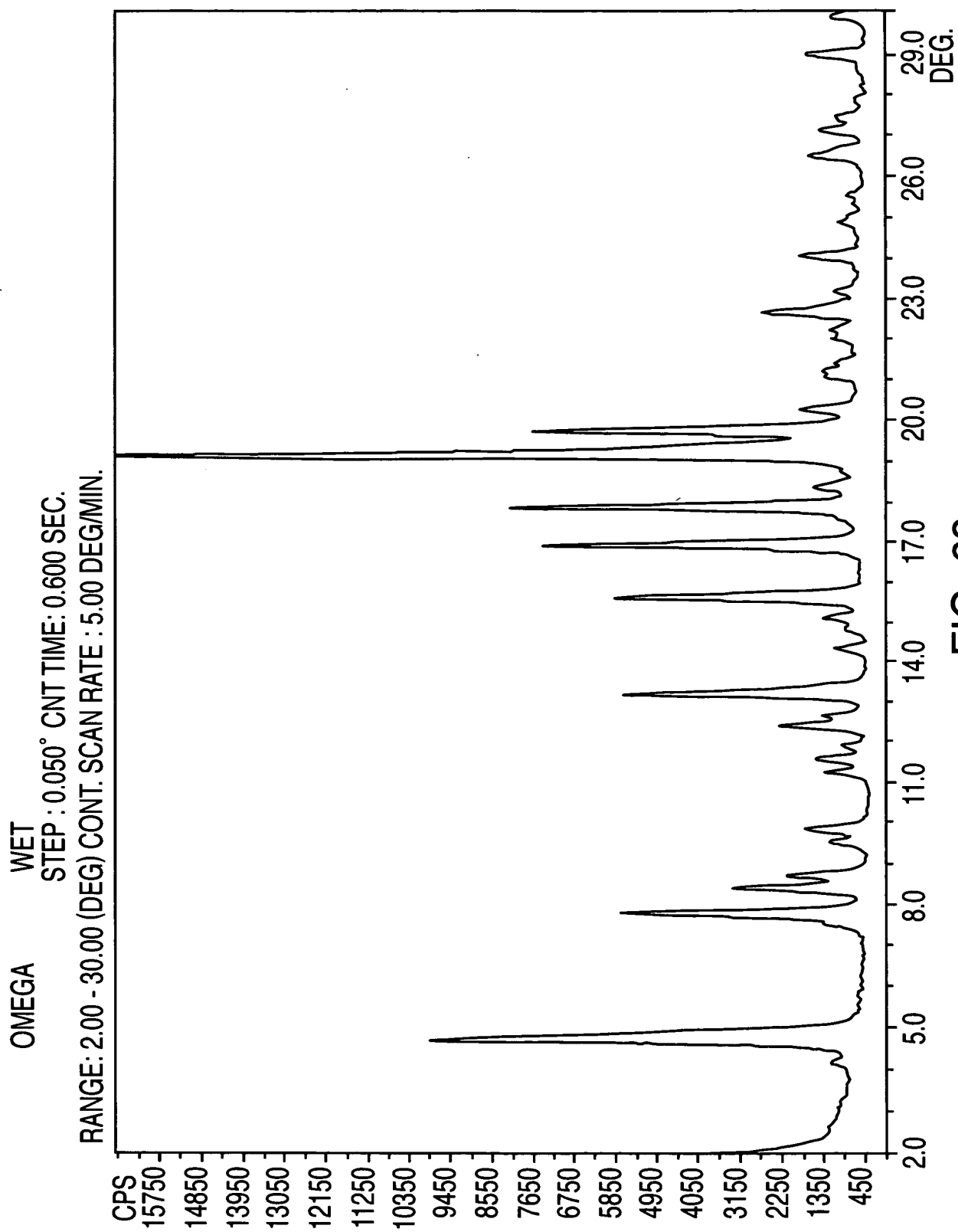


FIG. 63

Comparison between the impurity profile of Nateglinide crystallized in IPA-H₂O and Nateglinide in Methanol-H₂O

Sample No	Solvent	Impurity profile by RRT [% w/w]								
		D-PA (0.23)	(0.25)	(0.46)	(0.80)	Ipcha (0.89)	Dimer (1.38)	Methyl Ester (1.51)	(1.76)	Isopropyl Ester (2.3)
RL-2155/1	Methanol-H ₂ O	<0.01		0.02	<0.01	0.03	0.02	2.91	0.04	
RL-2163/4	IPA-H ₂ O	<0.01	0.04		0.02	0.02	0.01		0.03	0.02

Note: D-PA means D-Phenyl Alanine

Ipcha means Iso propyl cyclohexyl carboxylic acid

Both are the starting materials of the product

(-)-N-[(trans-4-isopropyl cyclohexane)carbonyl]-D-phenylalanine

FIG. 64